

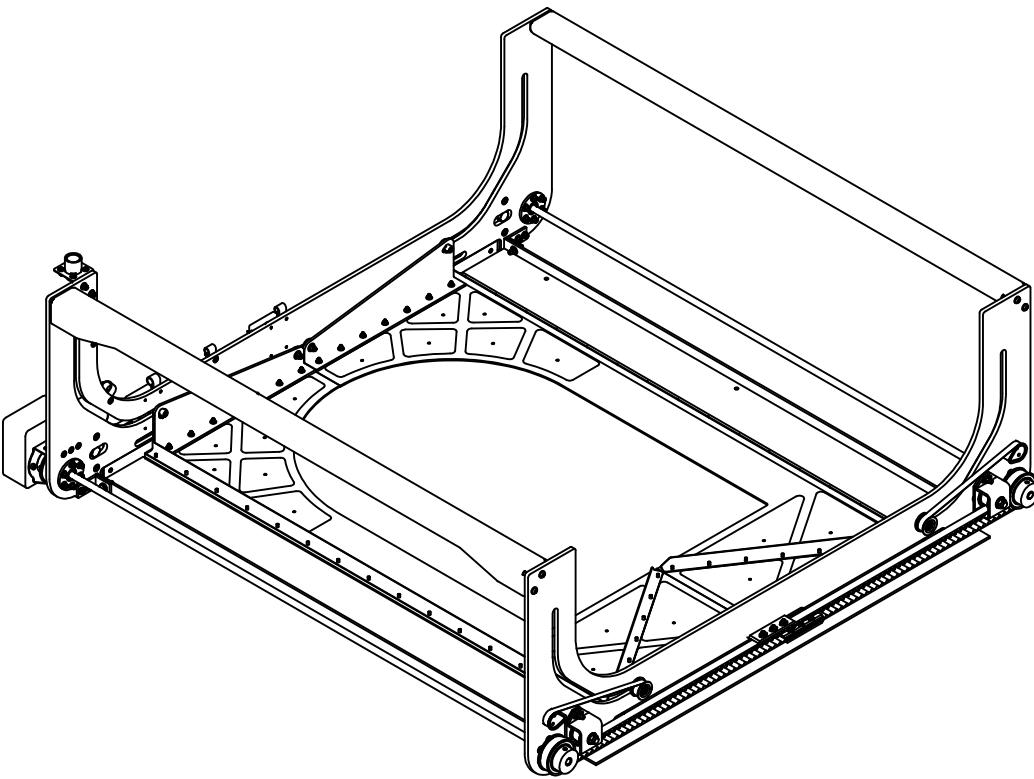
REVISION HISTORY

SHEET	REV	DATE	DESCRIPTION	AUTHOR	APPROVED	CHECKED BY
ALL	A	10/24/17	MULTIPLE DIMENSION CORRECTIONS. -17 & -18 ; CHANGED STOCK TO 0.125" X 1.00" X 1.00", -20 CHANGED ANGLE FROM 15.8 TO 16 DEGREES, -21 ADDED "TYP/2X" TO DIMENSIONS .500 & 0.25". -29 ADDED BEND CHART; ADDED -52, -9 REPLACED RIVET MS20426A4-7 WITH MS20426A4-7, -41 REPLACED RIVET MS20426A4-7 WITH MS20470AD4-7. -13 AND -14 INCREASE SIZE OF CUTOUT AND SHORTEN OVERALL LENGTH BY 0.020 EACH SIDE.	JT	JT	LS
	B	02/09/18	ON -12, CHANGED 0.130 DIA. (3X) FOR CLAMPS TO 0.177; CHANGED MATERIAL OF -37, -38, -54 WAS TEFLON; ON -41 CHANGED TO SOLID RIVETS WAS MS20470AD4-7; ADDED MASKED AREA TO -46; ADDED NOTE 1 TO PAGE 1, RE-NUMBERED OTHER NOTES; ADDED FASTENER TORQUES; ON -12 AND -40 ADDED SLOT DIMENSIONS; ADDED MASKED AREA TO -45; DELETED -50 AND -51; ON -27 AND -28, ADDED ANGULAR ALIGNMENT; ADDED DETAIL E ON SHT 8, WHICH INCLUDES RT-6000-1 AND HARDWARE; ON SHT 6 NOTE 5, CHANGED 'BOTTOM' TO 'TOP'; ON SHT 8 NOTE 8, CHANGED 'BOTTOM' TO 'TOP'; UPDATED STOCK ON PARTS -12, -13, -14, -15, -16, -17, -18, -19, -20, -21, -22, -23, -25, -26, -27, -28, -29, -30, -32, -35, -36, -40, -43, -46, -52; UPDATED MATERIAL SPEC ON PARTS -19, -27, -28, -39; ON -15 AND -16 MASK AREA WAS 'OTHER SIDE'; DELETED -13, -14, -15, -16, -36, -42, -44, -45, -52; ADDED -60, -61, -62, -63, -64, -65, -66, -67, -68, -69, -70, -71, -73.	JT	JT	LS
	C	7/6/18	REPLACED -13, -14, AND -36 DIBOND DOORS WITH -75, -76, -77 ALUMINUM DOORS; -15 AND -16 BRACKET HOLE VERTICAL LOCATIONS WERE 2.285 AND 0.910; ADDED -81 & -82 STIFFENERS FOR ALU DOORS, MS24693-S52 WAS MS24693-S51, MS25281-R3 WAS MS25281-R4, MS25281-R4 WAS MS25281-R5, MS35206-230 WAS MS35206-229; ADDED SHT. 9 BONDING TEST PROCEDURE. ADDED HOLE CALLOUT TO -52. SHT 52853 ADDED REFERENCE DIMENSION FOR TAB HEIGHT; ADDED HOLE SIZE DIMENSION; SHT 52, CHANGED -81 TO MIRROR -82 EXACTLY; ADDED MISSING DIMENSIONS ON -15, -76 AND -77	KEW	KEW	LS
	D	12/18/18	ADDED NOTE 6 ON DOOR ASSEMBLY SQUARE FIT ON -1 & -2 POD DOOR ASSEM; CHANGED -1 & -2 POD DOOR ASSEM BONDING TEST VALUE TO 10 mΩ; ADDED -87, -88, -89, -90, -91, -92, -93; ADDED MOUNTING HOLES TO -15, -16, -40; ADDED RIVETS AND NUT PLATES TO -78, -79, -80; UPDATED MASKING ON -15, -16, -40; REMOVED CAD REFERENCE IN -12, ADDED ASSEMBLY SQUARE INSPECTION TO -1 & -2 ASSEMBLY; CHANGED NOTE NUMBERS TO PER SHEET; ADDED REF TO -1 DOORS; REMOVED CAD PROFILE REFERENCE FROM -29, -35, -75, -76, -77; REMOVED GD&T FROM -27, -28, -29, -89, -90; DOTTED ANODIZING MASKING ZONES; ADDED ROHS COMPLIANCE TO -90 BLACK OXIDE; CHANGED 35.000 DIM TOLERANCE ON -35; CHANGED SIDE DIM TOLERANCES ON -46; UPDATED BLACK OXIDE AND LUBRICATION SPECIFICATION FOR -90; ADDED OPTIONAL DOOR FINISHES; UPDATED PTFE SPECS; ADDED NOTE 4 TO SHT 9; ADDED RIB DIMS & CORNER RADIUS TO -75/-76/-77; UPDATED -90 MATERIAL & FINISH SPEC	CMK	CMK	LS
	E	5/23/19	-15 & -16 UPDATED SECTION AB1 DIM FROM RADIUS TO EDGE WAS .980 NOW 1.000; -31 ADDED HEIGHT DIMENSIONS; -52 BEND RADIUS FROM R0.06 TO R0.12 AND OVERALL FLAT WIDTH TOLERANCE +/-0.030; ADDED MS51964-53 SET SCREWS; CHANGED TO -97 DOOR GEAR MOTOR WITH RELEVANT ASSEMBLY INSTRUCTIONS; REMOVED ES50204-1 DOOR MOTOR COUPLER; MODIFIED -6 IDLER PULLEY ASSEMBLY TO USE -96 BUSHING IN PLACE OF WASHER STACK; CHANGED BOTH -27 & -28 SHAFTS TO SINGLE FLAT DESIGN, -28 DRIVE SHAFT HAS COUPLING PORTION REMOVED; -29 MOTOR MOUNT CHANGED TO MATE TO -97 GEAR MOTOR; -32 SWITCH BRACKET MOUNTING SURFACE OUT 0.040 FOR CLEARANCE; -94 BUSHING ADDED; -95 TIMING PULLEY ADDED; -96 BUSHING ADDED; -97 GEAR MOTOR ADDED; -98 DRIVE TIMING PULLEY ASSEM ADDED; SHT 9 PULLEY ORIENTATION DETAIL ADDED; CORRECTED -98 PAGE TITLE	CMK	CMK	LS
1-11	F	5/7/20	MODIFIED -10/-11 TO INCLUDE RT-1000-87 LIMIT SWITCH WITH CAP NUT, WASHERS, AND SCREW	CMK	CMK	LS
	G	11/16/21	-1 & -2 ASSYS: REPLACED ALL AN960JD8J WASHERS WITH NAS1149DN832J; SHT 4: ADDED CG LOCATIONS AND TOTAL MASS	ZA	EW A	DT

		TITLE		DRAWING NUMBER	
		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES					
TOLERANCES EXCEPT WHERE NOTED:					
.X = ±.1					
.XX = ±.05					
.XXX = ±.010					
ANGLES = ± 1°					
THREADS:					
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EXTERNAL CLASS 2A					
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	4	AN3-5A	BOLT
3	1	C208RT-2000-3	MOTOR ASSEM
4	2	C208RT-2000-7	CARRIAGE ASSEM
5	2	C208RT-2000-8	CARRIAGE ASSEM
6	1	C208RT-2000-9	MAIN PLATE ASSEM (MOTOR SIDE)
7	1	C208RT-2000-10	D.O. LIMIT SWITCH ASSEM
8	1	C208RT-2000-11	D.C. LIMIT SWITCH ASSEM
9	2	C208RT-2000-25	LONG MOUNT
10	1	C208RT-2000-27	SECONDARY SHAFT
11	1	C208RT-2000-28	DRIVE SHAFT
12	4	C208RT-2000-30	BRACKET
13	4	C208RT-2000-31	BELT CLIP
14	4	C208RT-2000-33	SHAFT SPACER
15	2	C208RT-2000-34	BELT
16	2	C208RT-2000-35	SUPPORT
17	4	C208RT-2000-38	TEFLON SPACER
18	8	C208RT-2000-39	BUSHING
19	1	C208RT-2000-41	MAIN PLATE ASSEM (OPPOSITE MOTOR)
20	1	C208RT-2000-43	CONNECTOR MOUNT
21	2	C208RT-2000-54	TEFLON SPACER
22	1	C208RT-2000-78	DOOR ASSEM A
23	1	C208RT-2000-79	DOOR ASSEM B
25	4	ES32030-1	SPLIT LOCK WASHER
26	8	ES39516-1	BEARING
27	4	ES39516-2	FLANGED BEARING
28	4	ES39523-1	THRUST WASHER
29	2	ES39527-1	FINISH WASHER
30	3	ES50205-1	TIMING PULLY
31	4	MS16998-32	SOCKET HEAD CAP SCREW
32	8	MS21042L3	NUT
33	4	MS21042L04	NUT
34	12	MS21042L06	NUT
35	24	MS21042L08	NUT
36	12	MS24667-10	FHSCS
37	6	MS24693-S52	SCREW
38	2	MS24693-S276	SCREW
39	2	MS25281-R2	CABLE CLAMP
40	1	MS25281-R3	CABLE CLAMP
41	2	MS25281-R4	CABLE CLAMP
42	10	MS27039-0809	SCREW
43	6	MS27039-0810	SCREW
44	2	MS27039-0811	SCREW
45	4	MS35206-215	SCREW
46	6	MS35206-227	SCREW
47	2	MS35206-230	SCREW
48	16	NAS1149D0332J	WASHER
49	8	NAS1149DN432J	WASHER
50	20	NAS1149DN632J	WASHER
51	43	NAS1149DN832J	WASHER
52	1	RT-6000-1	DOORS SCHEMATIC
105	1	C208RT-2000-87	LIGHTNING BONDING ASSEM RIGHT
107	1	C208RT-2000-88	LIGHTNING BONDING ASSEM LEFT
108	1	C208RT-2000-98	DRIVE TIMING PULLEY ASSEMBLY



-1 RT POD DOOR ASSEM

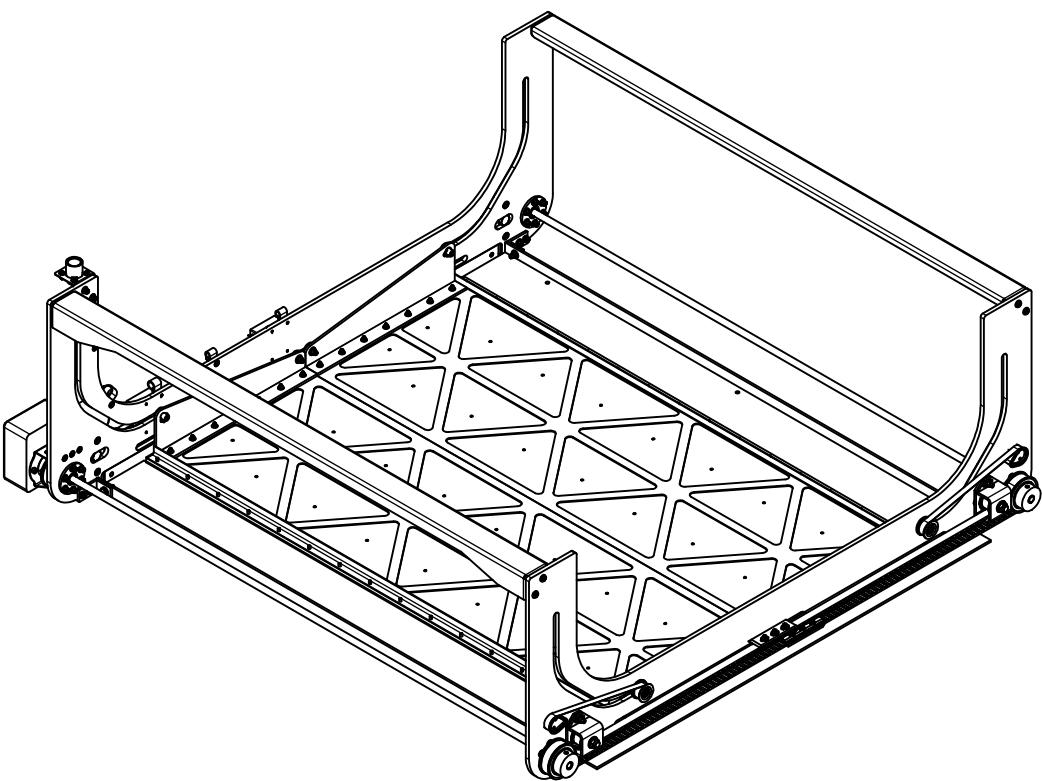
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18	8	C208RT-2000-39	BUSHING
19	1	C208RT-2000-41	MAIN PLATE ASSEM (OPPOSITE MOTOR)
20	1	C208RT-2000-43	CONNECTOR MOUNT
21	2	C208RT-2000-54	TEFLON SPACER
24	2	C208RT-2000-80	DOOR ASSEM C
25	4	ES32030-1	SPLIT LOCK WASHER
26	8	ES39516-1	BEARING
27	4	ES39516-2	FLANGED BEARING
28	4	ES39523-1	THRUST WASHER
29	2	ES39527-1	FINISH WASHER
30	3	ES50205-1	TIMING PULLEY
31	4	MS16998-32	SOCKET HEAD CAP SCREW
32	10	MS21042L3	NUT
33	4	MS21042L04	NUT
34	12	MS21042L06	NUT
35	24	MS21042L08	NUT
36	12	MS24667-10	FHSCS
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38	2	MS24693-S276	SCREW
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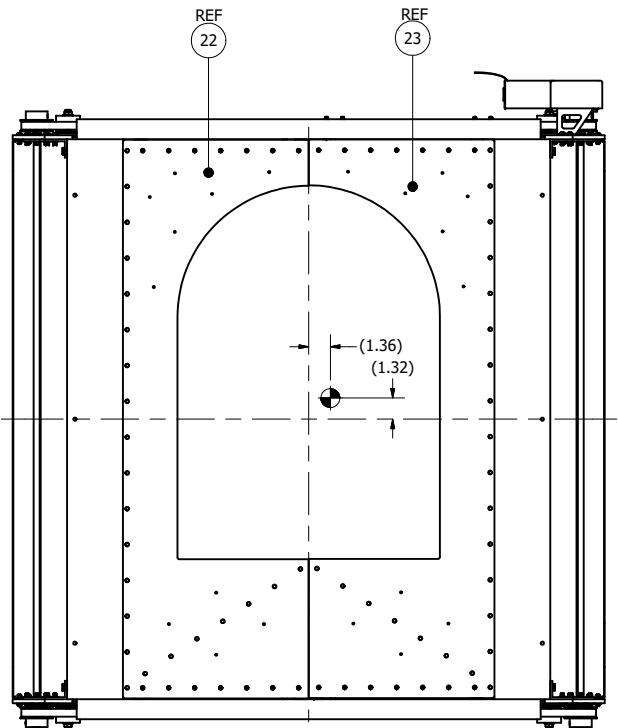
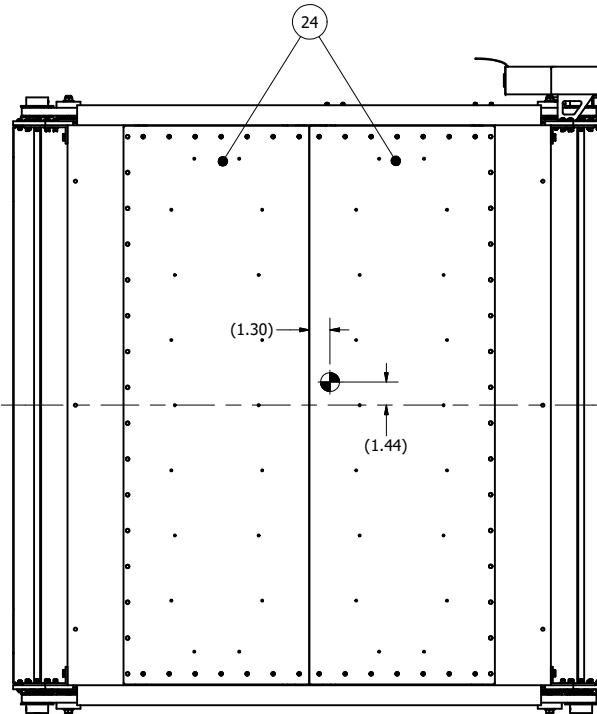
-2 RT POD DOOR ASSEM

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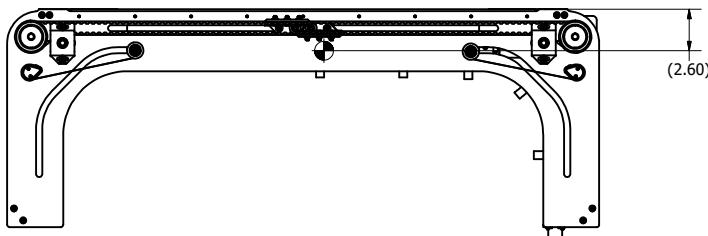
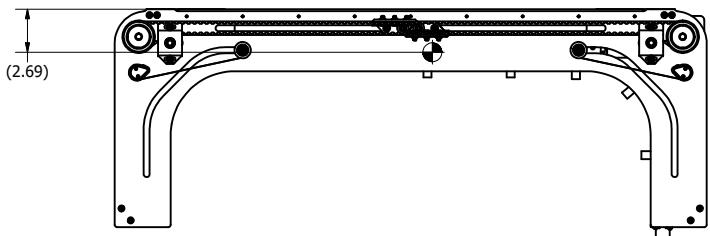
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Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16	REV G	ECO
DO NOT SCALE DRAWING					
3RD ANGLE PROJECTION					
INTERNAL: CLASS 2B EXTERNAL: CLASS 2A					
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-1 RT POD DOOR ASSEM-2 RT POD DOOR ASSEM

FORWARD ->



NOTES:

1. THE -1 AND -2 CARGO POD DOOR ASSEMBLIES ARE IDENTICAL EXCEPT FOR THE INSTALLATION OF THE DOORS.
2. -1 TOTAL MASS = 26.2 LB
3. -2 TOTAL MASS = 27.3 LB

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THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING 3RD ANGLE PROJECTION		REV G ECO	
4	1	3	2	1	A

-1 & -2 RT POD DOOR ASSEM
EXPLODED VIEW OPPOSITE MOTOR

D

C

B

A

4 1 3 2 1 1

4 3 2 1 1

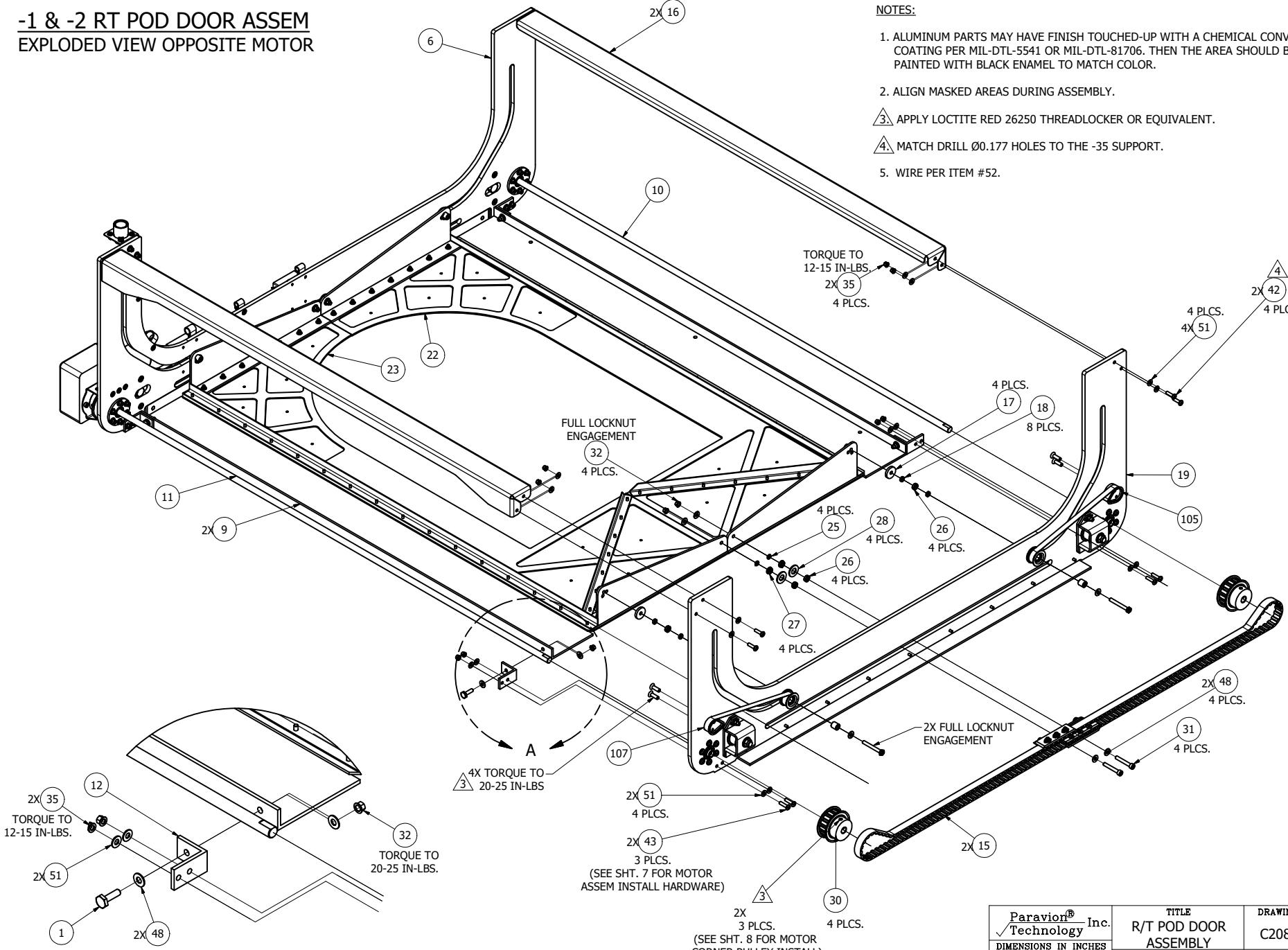
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1

NOTES:

1. ALUMINUM PARTS MAY HAVE FINISH TOUCHED-UP WITH A CHEMICAL CONVERSION COATING PER MIL-DTL-5541 OR MIL-DTL-81706. THEN THE AREA SHOULD BE PAINTED WITH BLACK ENAMEL TO MATCH COLOR.
2. ALIGN MASKED AREAS DURING ASSEMBLY.
3. APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT.
4. MATCH DRILL Ø0.177 HOLES TO THE -35 SUPPORT.
5. WIRE PER ITEM #52.



Paravion® Technology		TITLE		DRAWING NUMBER	
R/T POD DOOR ASSEMBLY		C208RT-2000			
DRAWN BY	CHK'D BY	APPR'D BY	DATE	REV	ECO
KEW	LS	NLH	7/8/16	G	
DO NOT SCALE DRAWING					SHEET
3RD ANGLE PROJECTION					5 OF 66

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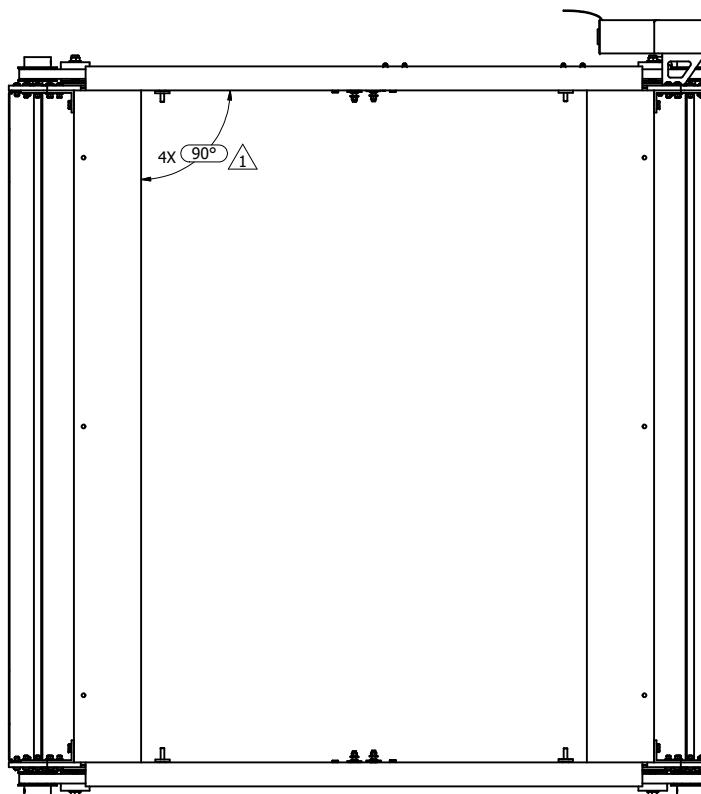
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EXTERNAL: CLASS 2A

-1 & -2 RT POD DOOR ASSEM

SQUARE ASSEMBLY

NOTE:

 ASSEMBLE FRAME, INSPECT WITH MACHINIST SQUARE - NO MORE THAN 0.010" GAP PER 6" SPAN.



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		KEW	LS	NLH	7/8/16	G	
 3RD ANGLE PROJECTION		DO NOT SCALE DRAWING				SHEET	
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-1 & -2 RT POD DOOR ASSEM

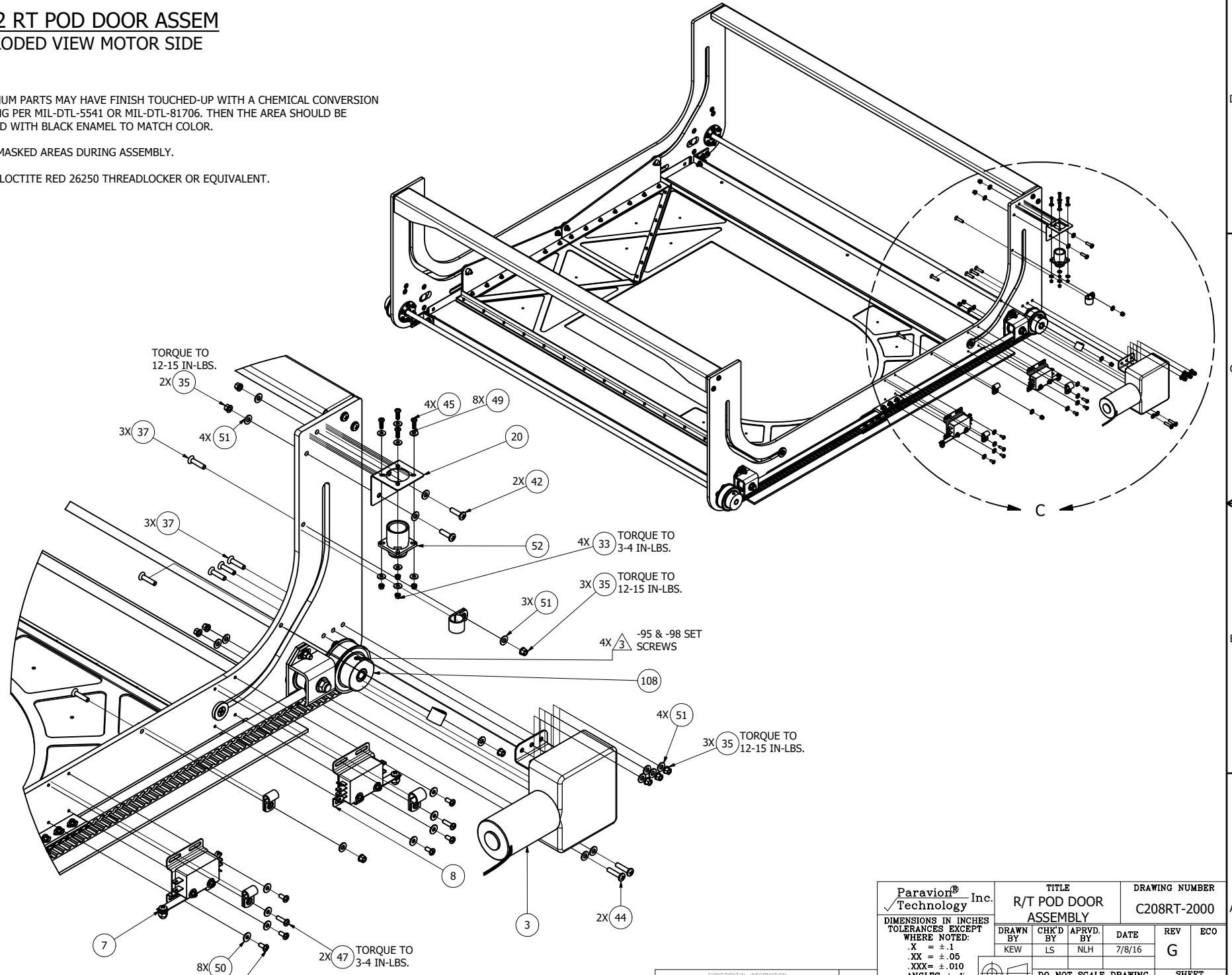
EXPLODED VIEW MOTOR SIDE

NOTES:

1. ALUMINUM PARTS MAY HAVE FINISH TOUCHED-UP WITH A CHEMICAL CONVERSION COATING PER MIL-DTL-5541 OR MIL-DTL-81706. THEN THE AREA SHOULD BE PAINTED WITH BLACK ENAMEL TO MATCH COLOR.

2. ALIGN MASKED AREAS DURING ASSEMBLY.

3. APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT.



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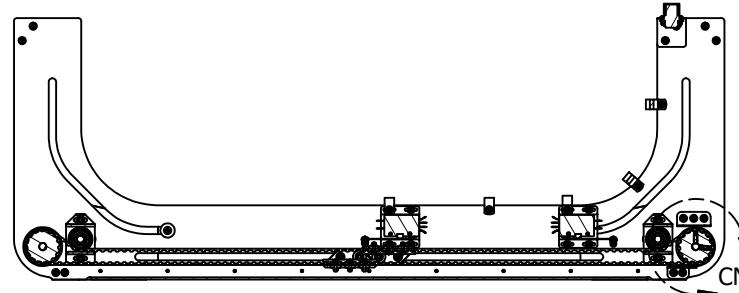
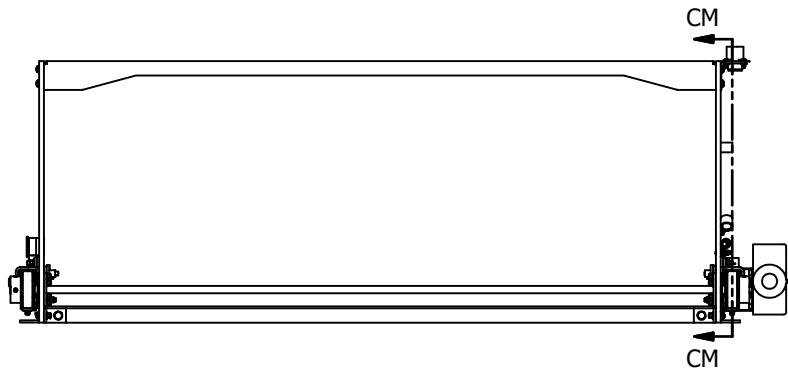
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KEW	LS	NLH	7/8/16	G	
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-1 & -2 RT POD DOOR ASSEM

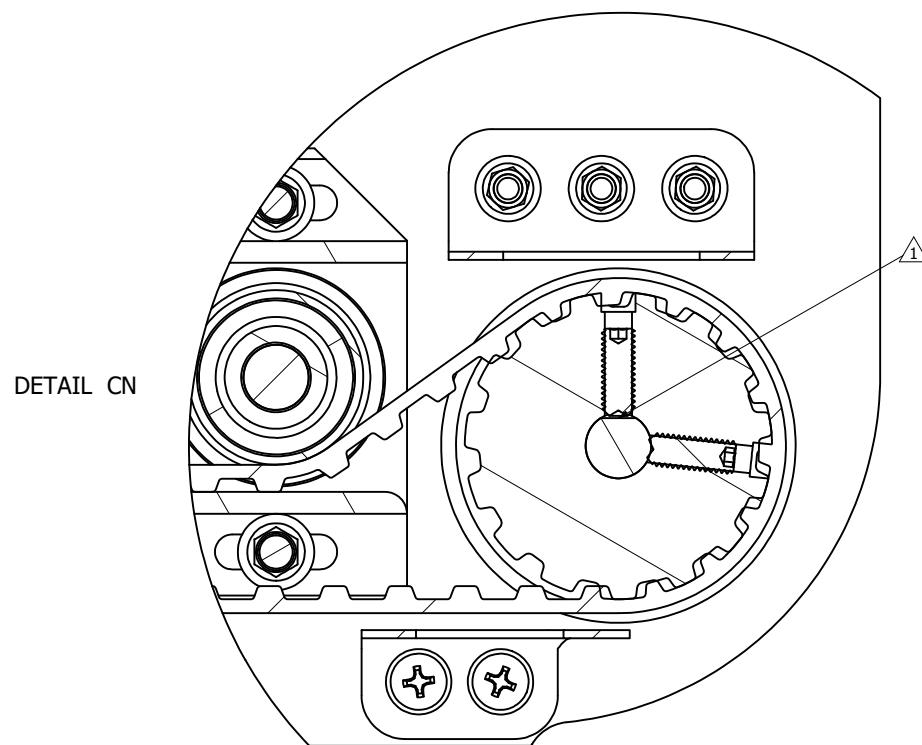
TIMING PULLEY ORIENTATION

NOTES:

1. WHEN FACING PULLEY FROM HUB SIDE, ALIGN PULLEY WITH SHAFT SO THAT SET SCREWS ARE LOCATED AT APPROXIMATELY 12 & 3 O'CLOCK WITH SHAFT FLAT FACING 12 O'CLOCK.



SECTION CM-CM



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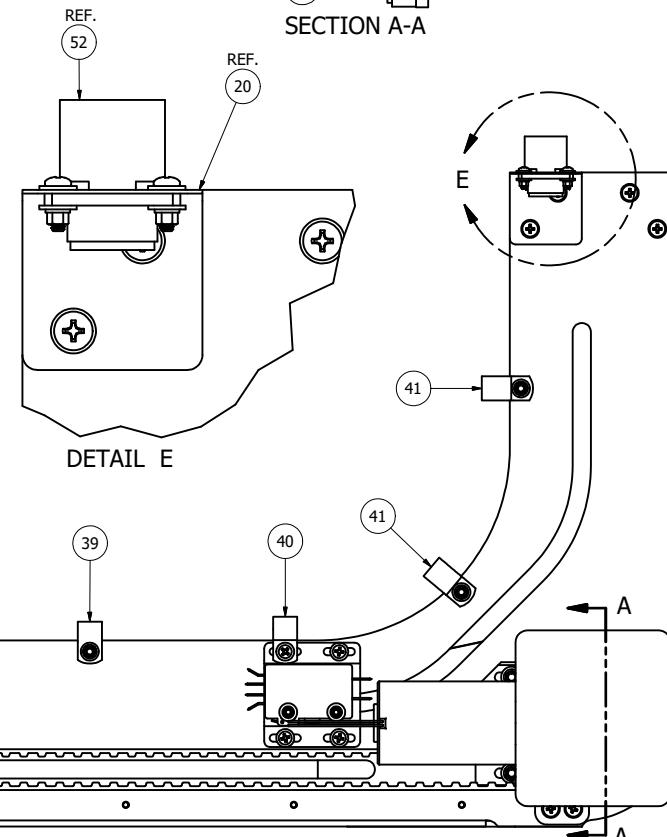
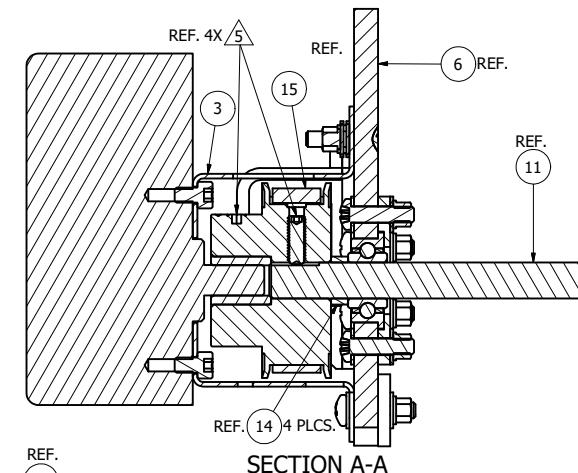
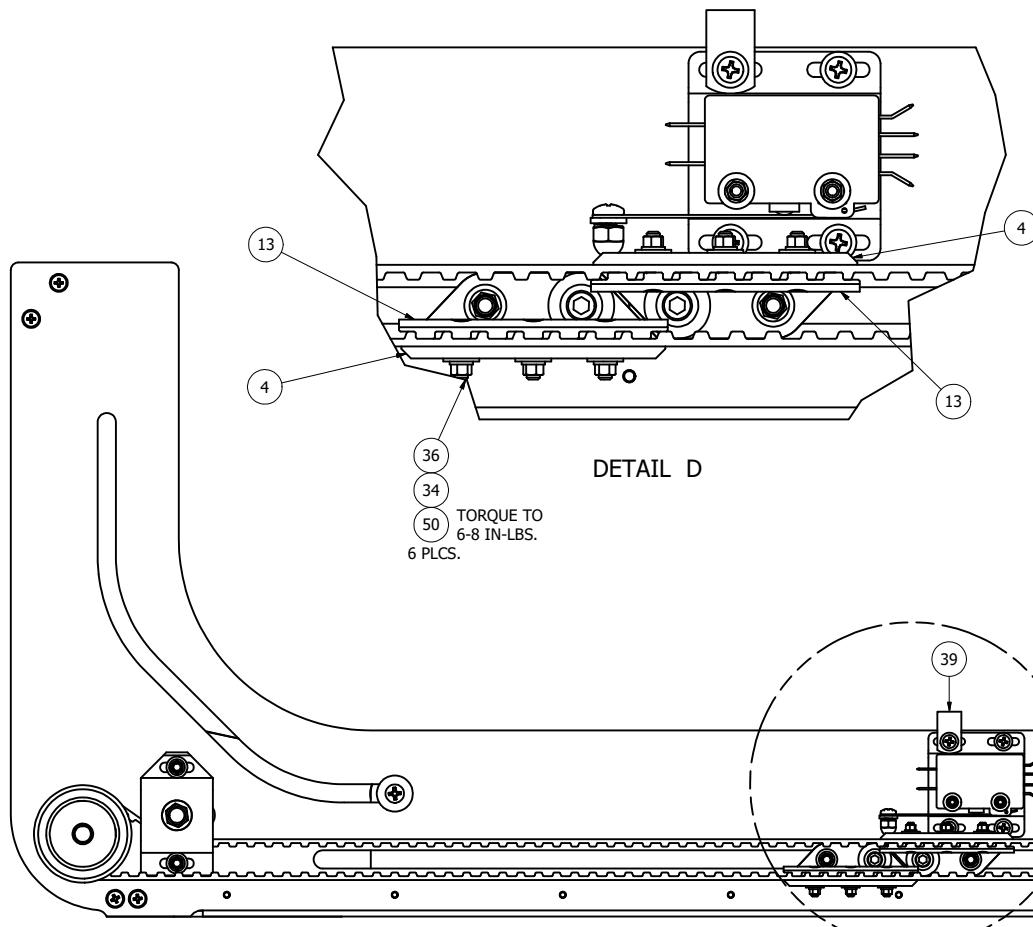
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			ANGLES = $\pm 1^\circ$		
THREADS:		3RD ANGLE PROJECTION		DO NOT SCALE DRAWING	
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-1 & -2 RT POD DOOR ASSEM

VIEW MOTOR SIDE

NOTE:

1. MATE BELT ENDS TOGETHER AT CENTER OF TOP CARRIAGE ASSEMBLY
2. MATCH DRILL BELT TO CARRIAGE ASSEMBLIES
3. ADJUST -7 CARRIAGES TO ALIGN DOORS.
4. SLIDE -6 IDLER PULLEYS TO TIGHTEN BELT, REMOVE BELT SLACK.
5. APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT.



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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPRVD. BY NLH	DATE 7/8/16	REV G	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	DO NOT SCALE DRAWING © 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.	1				
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-1 & -2 RT POD DOOR ASSEM BONDING TEST PROCEDURE

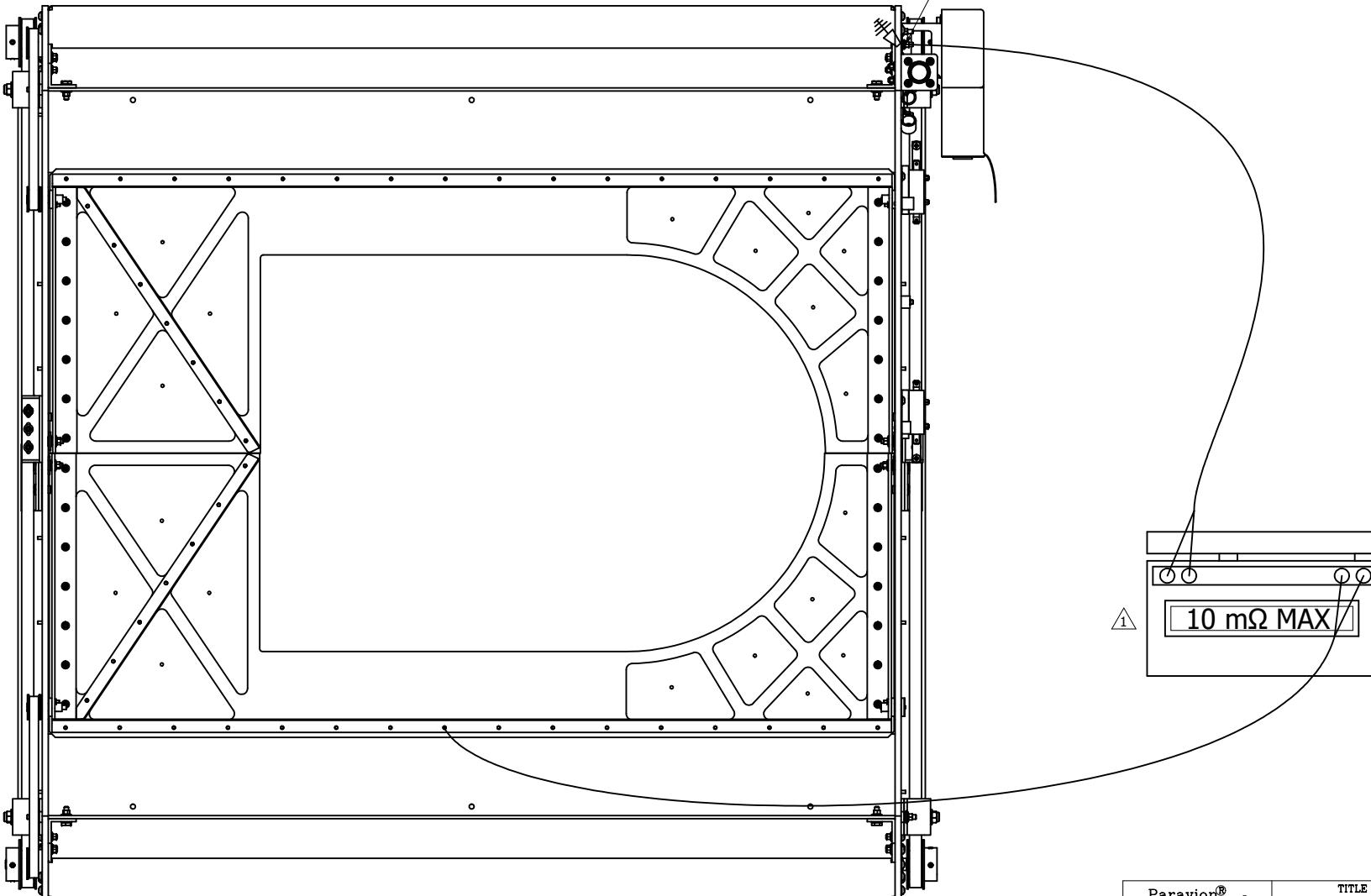
TOP VIEW

NOTE:

D **1** COMPLETED ASSEMBLY MUST BE TESTED TO VERIFY ELECTRICAL BOND:

- ASSEMBLE C208RT-2000-1 / -2 R/T POD DOOR ASSEMBLY.
- USING CALIBRATED MILI-OHMETER, TEST RESISTANCE ACROSS FRAME AT INDICATED AREAS, NOT TO EXCEED 10 MILI-OHM (0.010 OHM). IF INDICATED VALUE IS HIGHER THAN LIMIT, DIAGNOSE WITH 2.5 MILI-OHM (0.0025 OHM) MAX PER JUNCTION.

CLAMP TO TOP, CENTER MOUNTING SCREW ON C208RT-2000-7 MOTOR ASSEM.



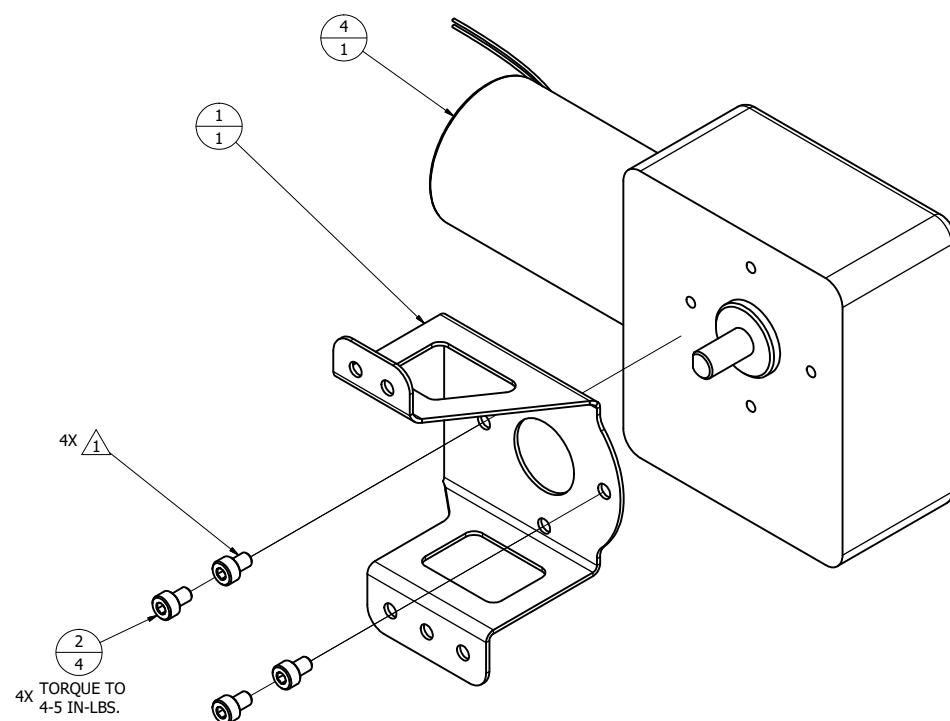
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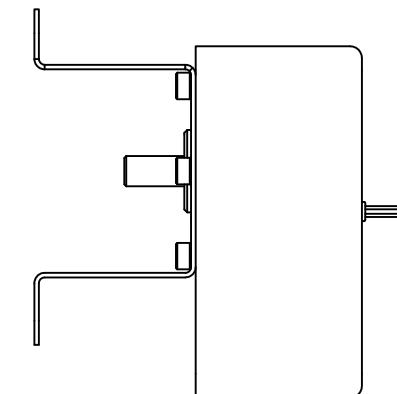
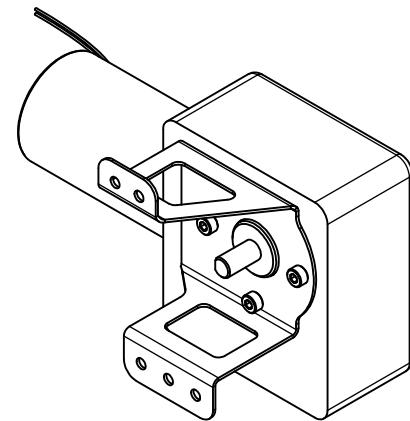
Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16	REV G	ECO
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°					
DO NOT SCALE DRAWING					
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-3 MOTOR ASSEM

⚠1 APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT.



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	C208RT-2000-29	MOTOR MOUNT
2	4	ES39525-1	SOCKET HEAD SCREW (ALT: ES39525-2)
4	1	C208RT-2000-97	WORM GEAR MOTOR

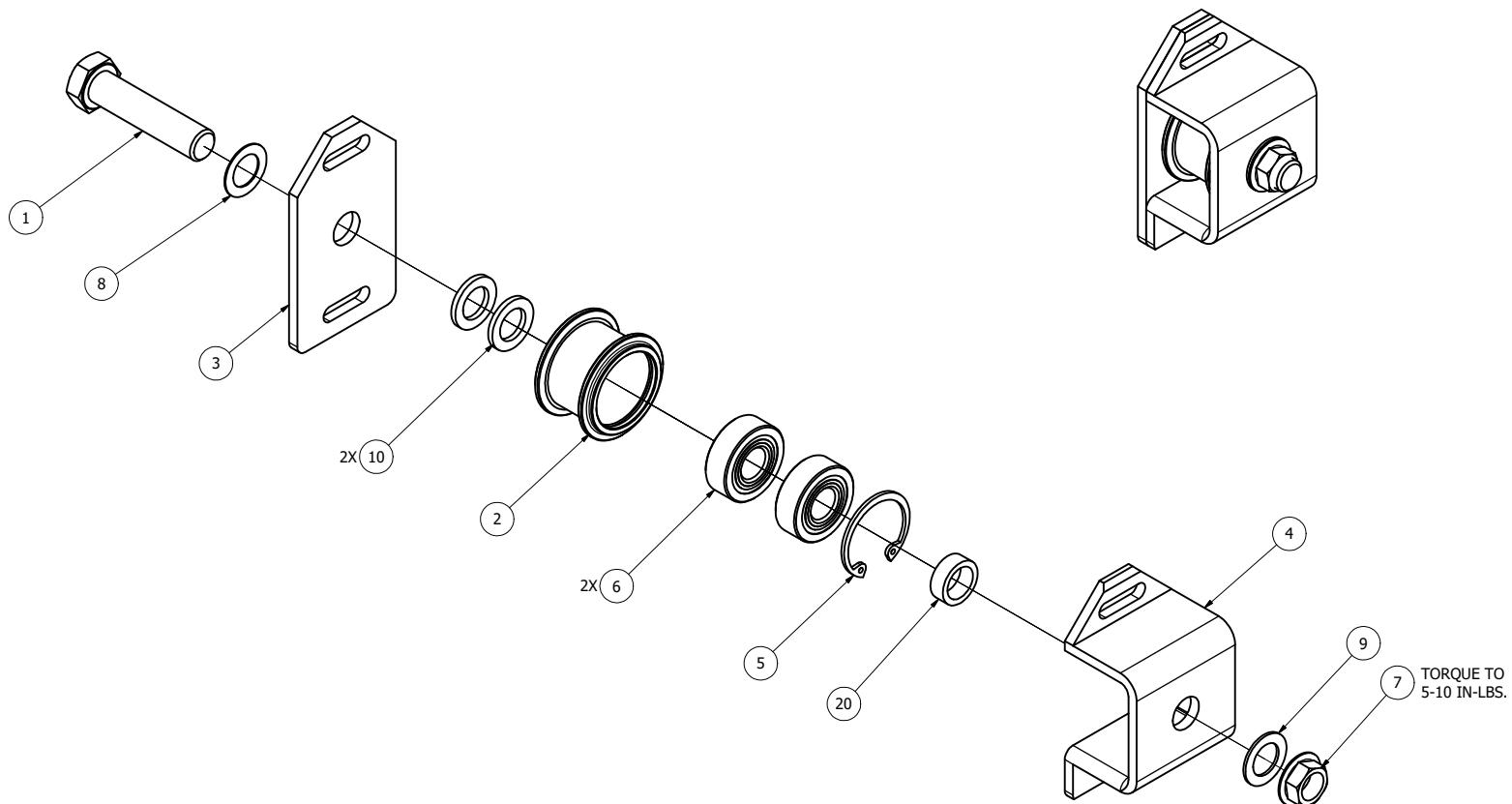


 Paravion® Inc. Technology	TITLE			DRAWING NUMBER	
	R/T POD DOOR ASSEMBLY			C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°					
DRAWN BY	CHK'D BY	APPROVED BY	DATE	REV	ECO
KEW	LS	NLH	7/8/16	G	
DO NOT SCALE DRAWING			SHEET		
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-6 IDLER PULLEY ASSEM



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PROTO		DO NOT SCALE DRAWING 3RD ANGLE PROJECTION © 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.					
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-7 CARRIAGE ASSEM

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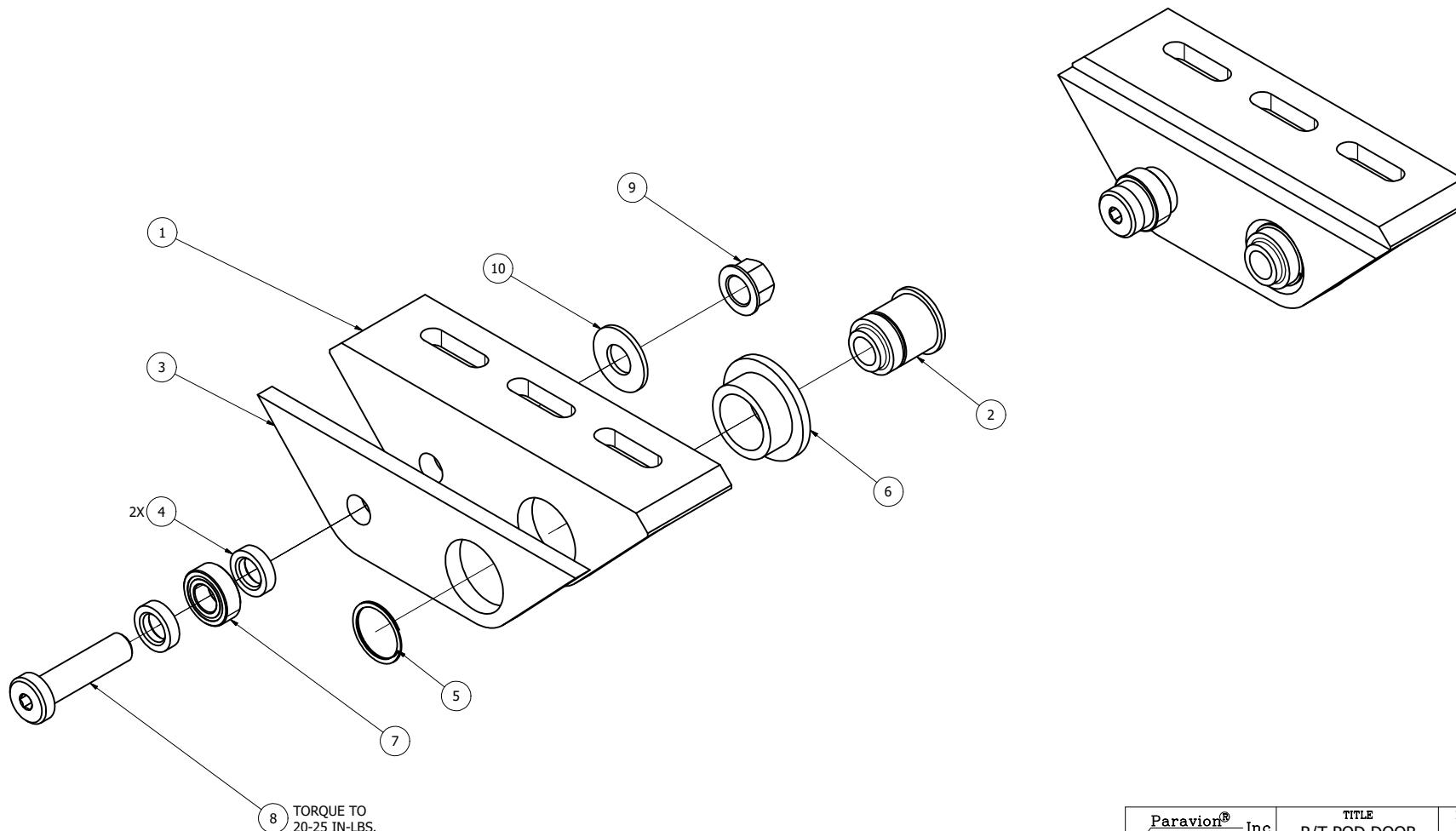
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	C208RT-2000-17	CARRIAGE
2	1	C208RT-2000-19	PIVOT
3	1	C208RT-2000-37	TEFLON SPACER
4	2	C208RT-2000-39	BUSHING
5	1	ES32020-1	EXTENAL RETAINING RING
6	1	ES39505-1	BUSHING
7	1	ES39516-1	BEARING
8	1	ES39526-1	SCREW
9	1	MS21042L3	NUT
10	1	NAS1149D0332J	WASHER



Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16
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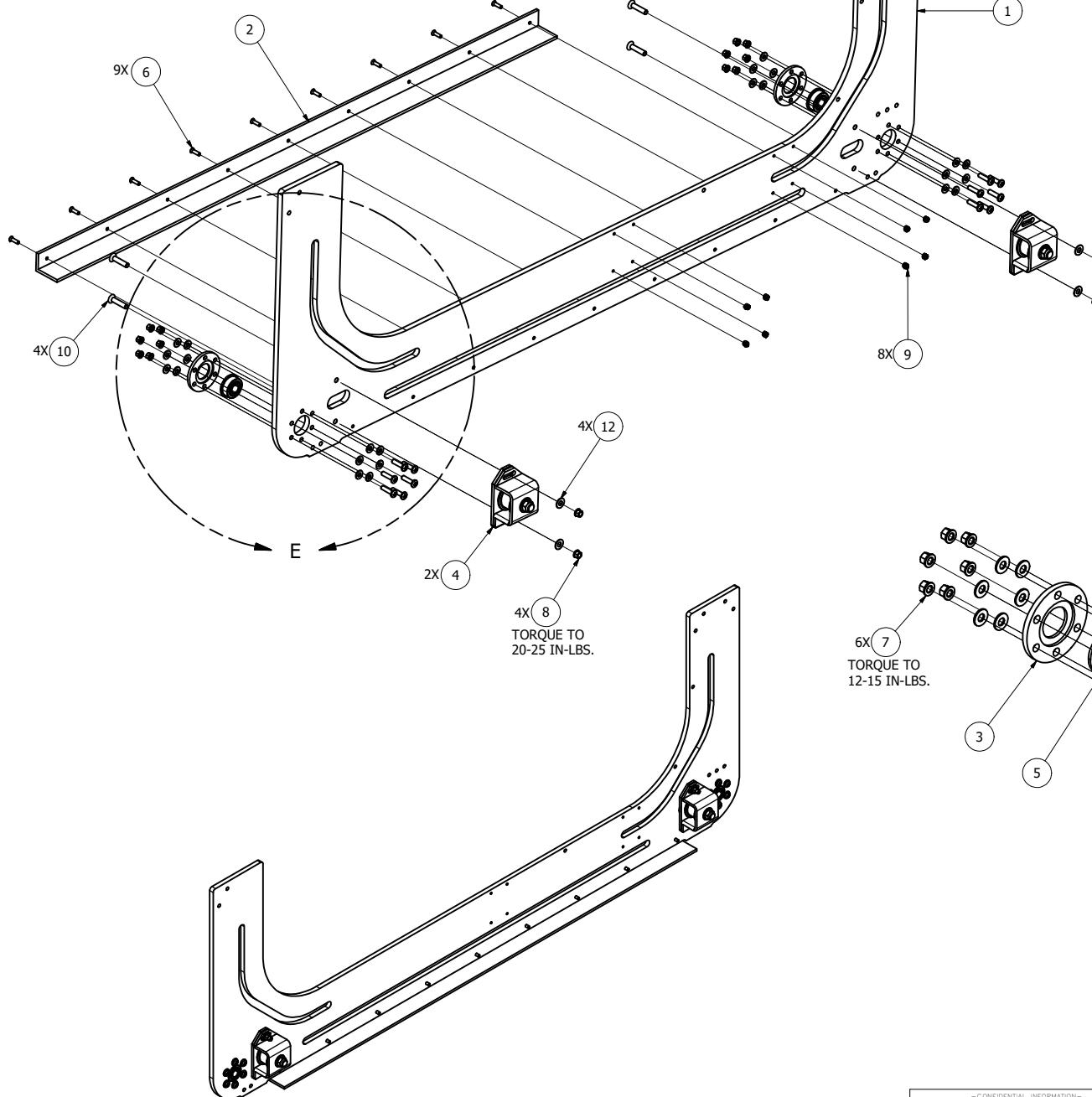
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-9 MAIN PLATE ASSEM (MOTOR SIDE)

NOTE:

1. INSTALL RIVETS PER AC43.13-1B, CHG. 1, CHAP 4, PARA 4-57.

2. ALIGN MASKED AREAS DURING ASSEMBLY.

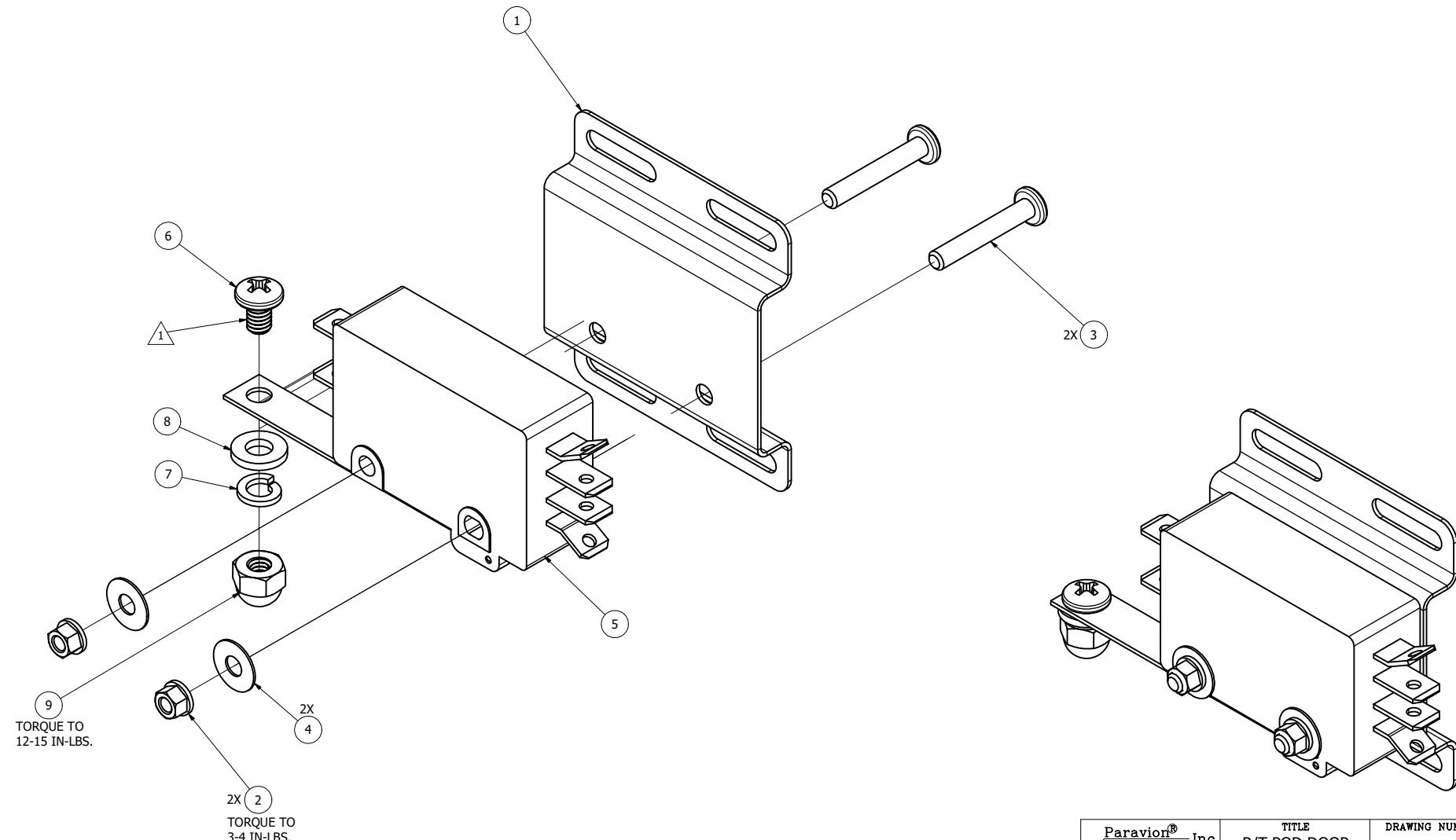


PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	C208RT-2000-12	MAIN PLATE (MOTOR SIDE)
2	1	C208RT-2000-23	LATERAL MOUNT
3	2	C208RT-2000-26	BEARING RETAINER
4	2	C208RT-2000-6	IDLER PULLY ASSEM
5	2	ES39516-3	FLANGED BEARING
6	9	MS20426AD4-7	RIVET
7	12	MS21042L08	NUT
8	4	MS21042L3	NUT
9	8	MS21209C0615	THREAD INSERT
10	4	MS24693S275	SCREW
11	12	MS27039-0810	SCREW
12	4	NAS1149D0332J	WASHER
13	24	NAS1149DN832J	WASHER

Paravion® Technology	TITLE R/T POD DOOR ASSEMBLY			DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
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-10 D.O. LIMIT SWITCH ASSEM

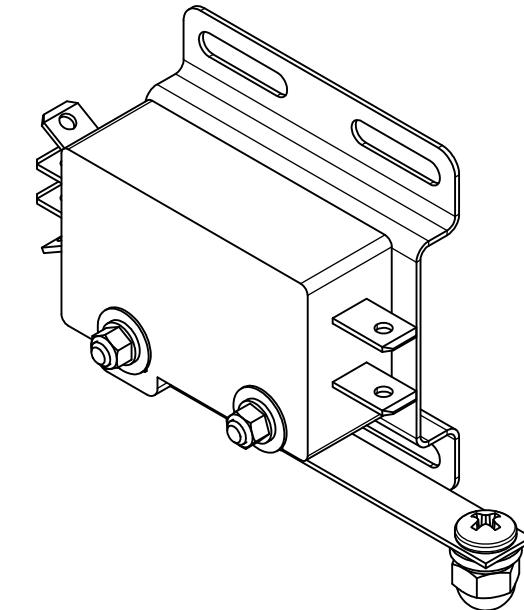
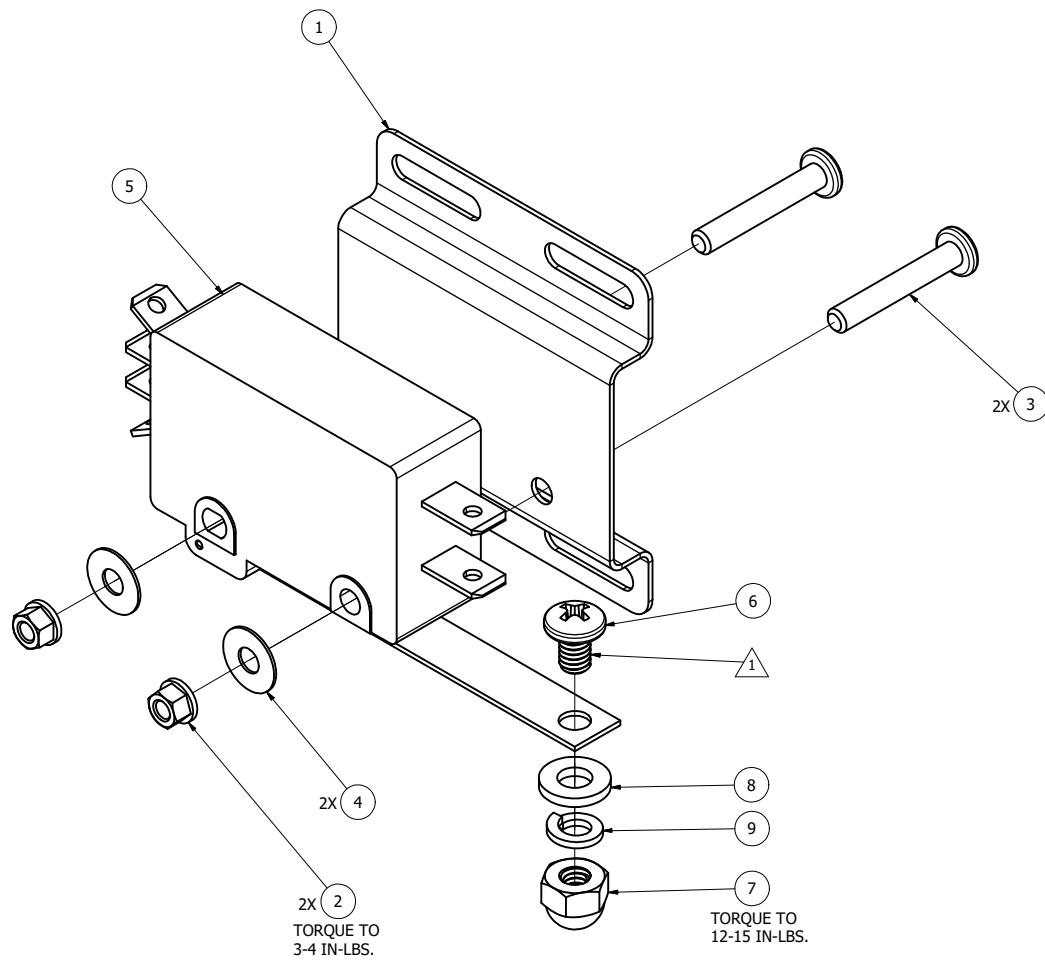
1. APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT.



Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = $\pm .1$.X = $\pm .05$.XXX = $\pm .010$ ANGLES = $\pm 1^\circ$		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16
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-11 D.C. LIMIT SWITCH ASSEM

⚠ 1. APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT.

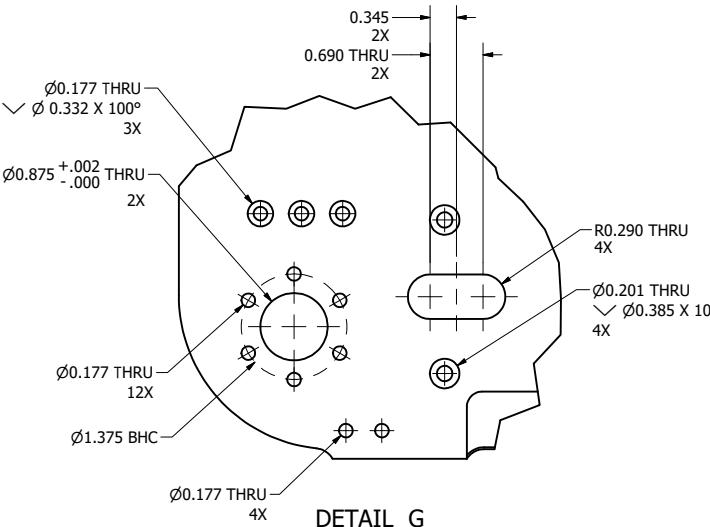
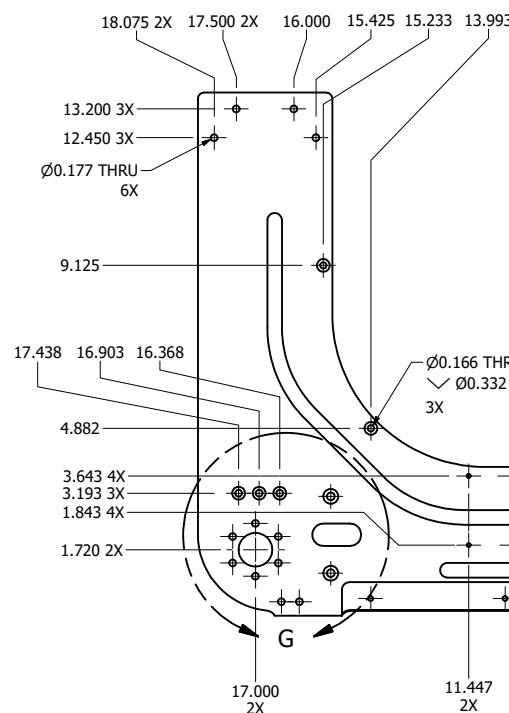


PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	C208RT-2000-32	SWITCH BRACKET
2	2	MS21042L06	NUT
3	2	MS35206-233	SCREW
4	2	NAS1149DN616J	WASHER
5	1	RT-1000-87	LIMIT SWITCH
6	1	MS51957-41	SCREW
7	1	ES39860-1	CAP NUT
8	1	MS9321-08	WASHER
9	1	MS35338-137	WASHER

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-12 MAIN PLATE (MOTOR SIDE) CONT'D



DETAIL G

BREAK ALL SHARP EDGES

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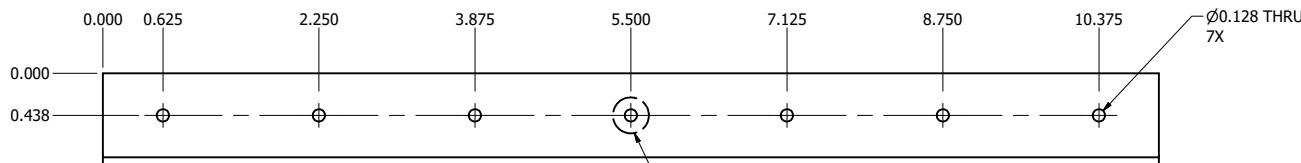
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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY	CHK'D BY	APPVD. BY	DATE
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ANGLES = ± 1°					
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-15 BRACKET

MATERIAL: 6061-T6, AMS 4150, ANS 4173, AMS-QQ-A-200/8
 STOCK SIZE: 0.125" X 1.00" X 3.00" X 11.25" EXTRUDED ANGLE
 FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
 COLOR: BLACK

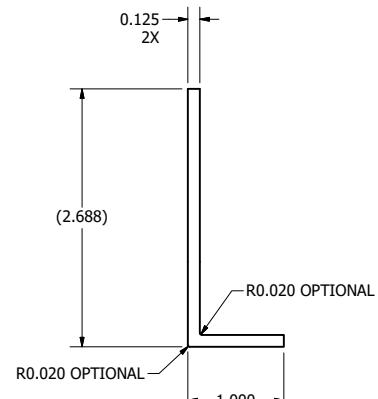
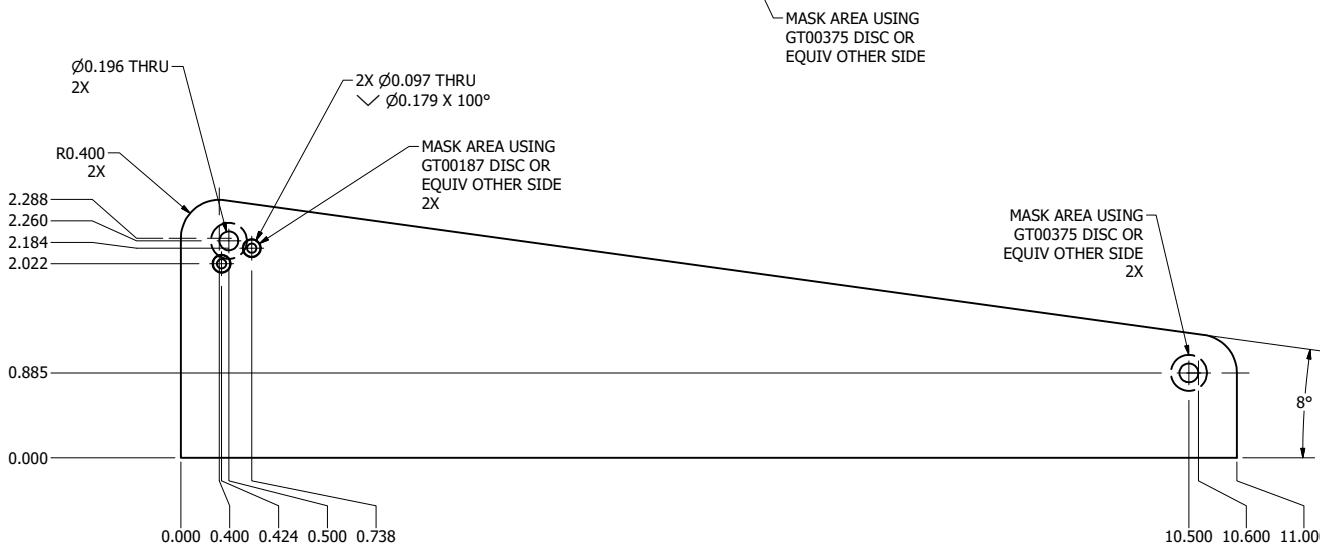
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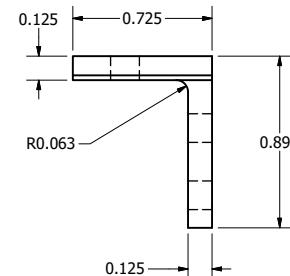
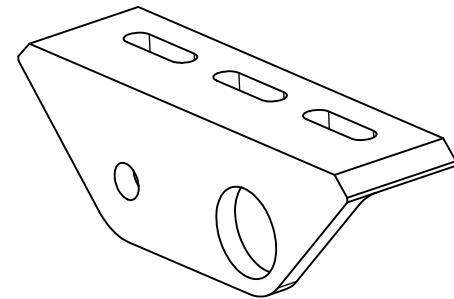
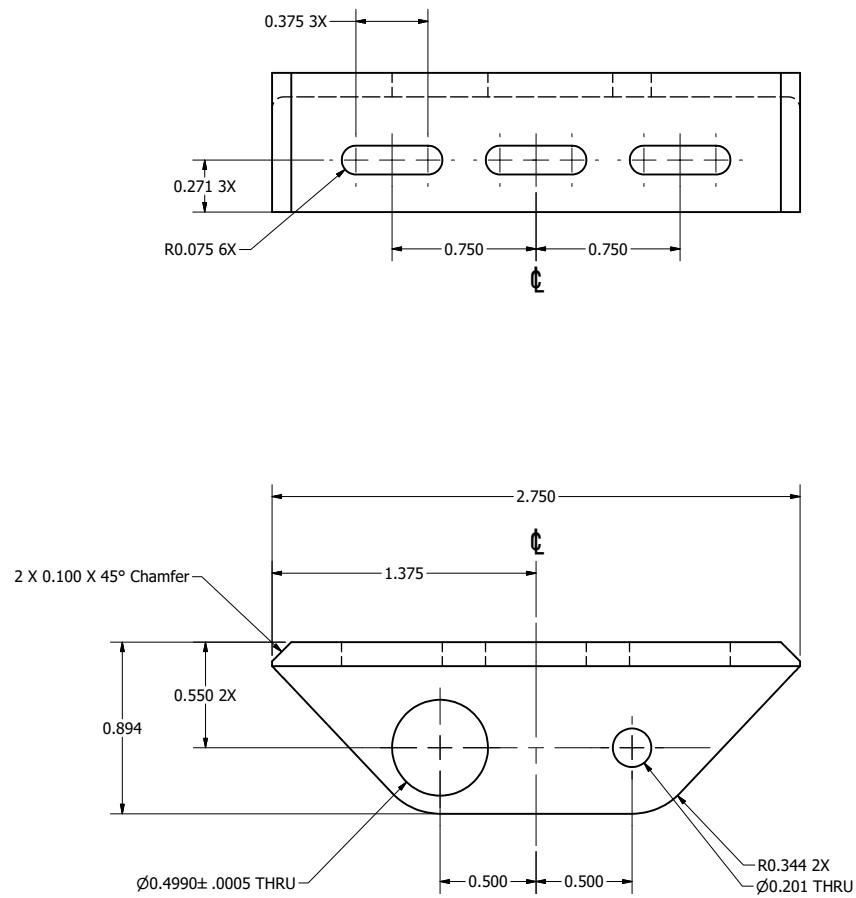
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-17 CARRIAGE

MATERIAL: 6061-T651, AMS 4128, AMS-QQ-A-225/8
STOCK SIZE: 0.125" THK EXTRUDED ANGLE
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
COLOR: BLACK



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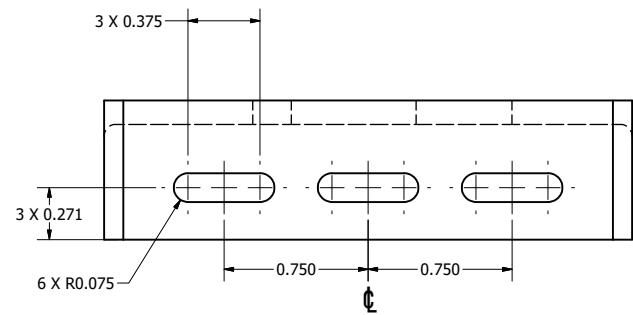
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		REV G	ECO		

-18 CARRIAGE

MATERIAL: 6061-T651, AMS 4128, AMS-QQ-A-225/8
 STOCK SIZE: 0.125" THK EXTRUDED ANGLE
 FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
 COLOR: BLACK

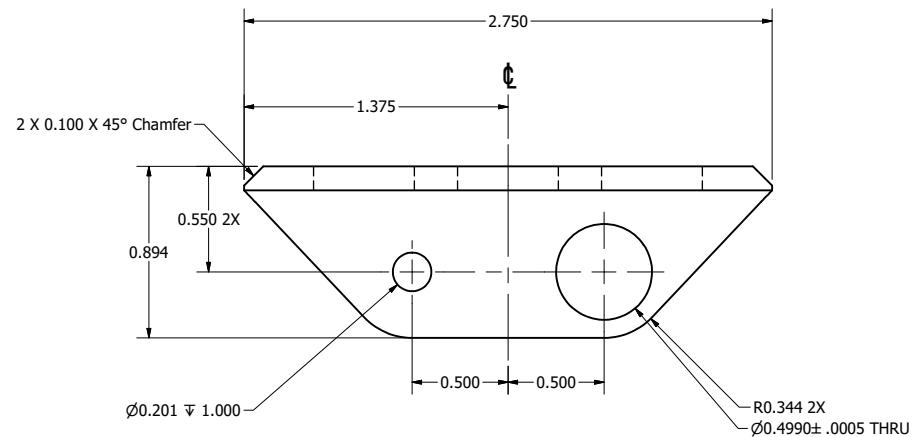
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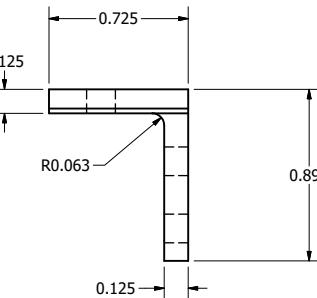
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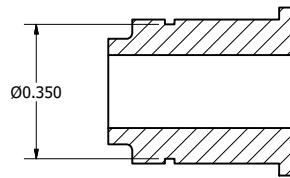
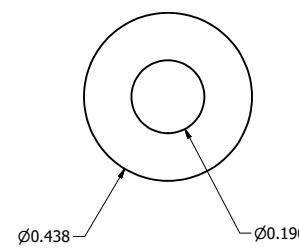
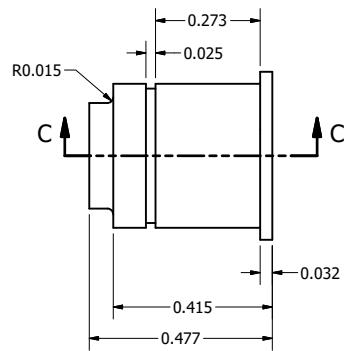
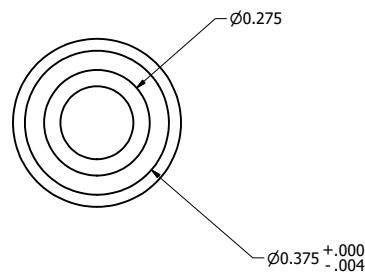
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-19 PIVOT

MATERIAL: 304 S.S. BAR OR ROD PER AMS 5639
STOCK SIZE: Ø 0.50" ROD
FINISH: NONE



SECTION C-C

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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES		TOLERANCES EXCEPT			
WHERE NOTED:		.X	= ±.1	DRAWN BY	CHK'D BY
		.XX	= ±.05	KEW	APPROVED BY
		.XXX	= ±.010	LS	DATE
			ANGLES=± 1°	NLH	7/8/16
THREADS:		DO NOT SCALE DRAWING		REV	
INTERNAL: CLASS 2B		3RD ANGLE PROJECTION		ECO	
EXTERNAL: CLASS 2A		© 2021 PARAVION TECH, INC.		G	
PROJECTION		PARAVION IS A TRADEMARK OF		SHEET	
PROJECTION		PARAVION TECHNOLOGY INC.		25 OF 66	

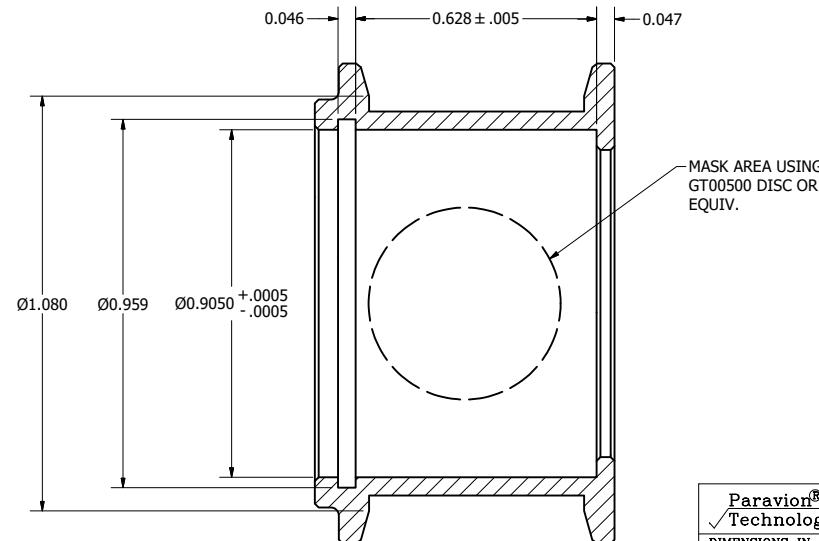
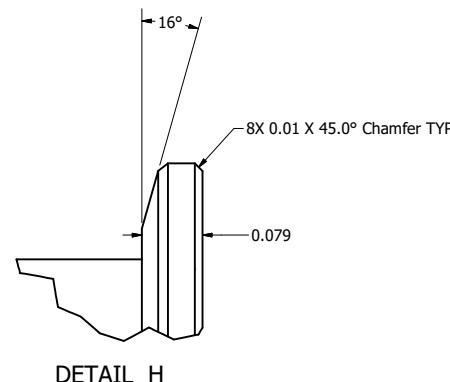
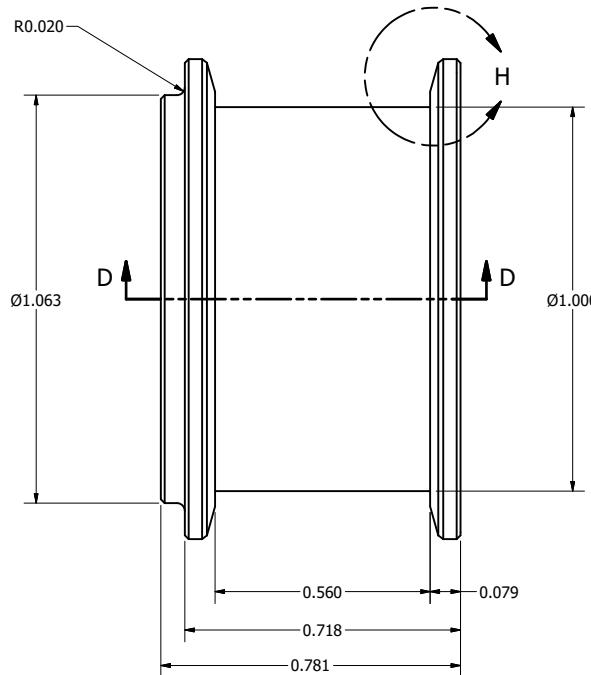
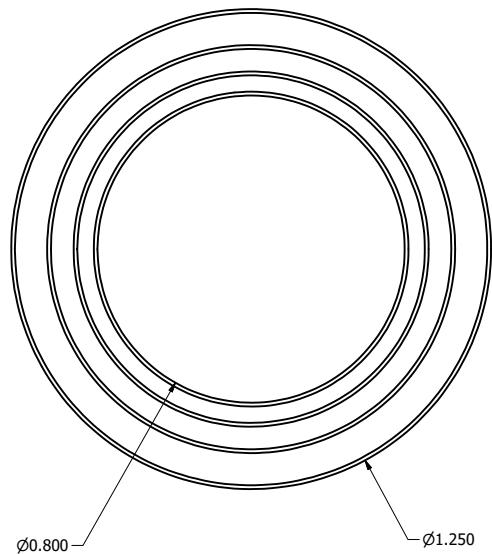
-20 IDLER PULLEY

MATERIAL: 6061-T651, AMS 4128, AMS-QQ-A-225/8

STOCK SIZE: Ø 1.250" ROD

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2

COLOR: BLACK



SECTION D-D

BREAK ALL SHARP EDGES

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PROTO

Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DRAWN BY	CHK'D BY	APPROVED BY	DATE	REV	ECO
KEW	LS	NLH	7/8/16		G
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DO NOT SCALE DRAWING			
.X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		SHEET			
INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			
3RD ANGLE PROJECTION		26 OF 66			

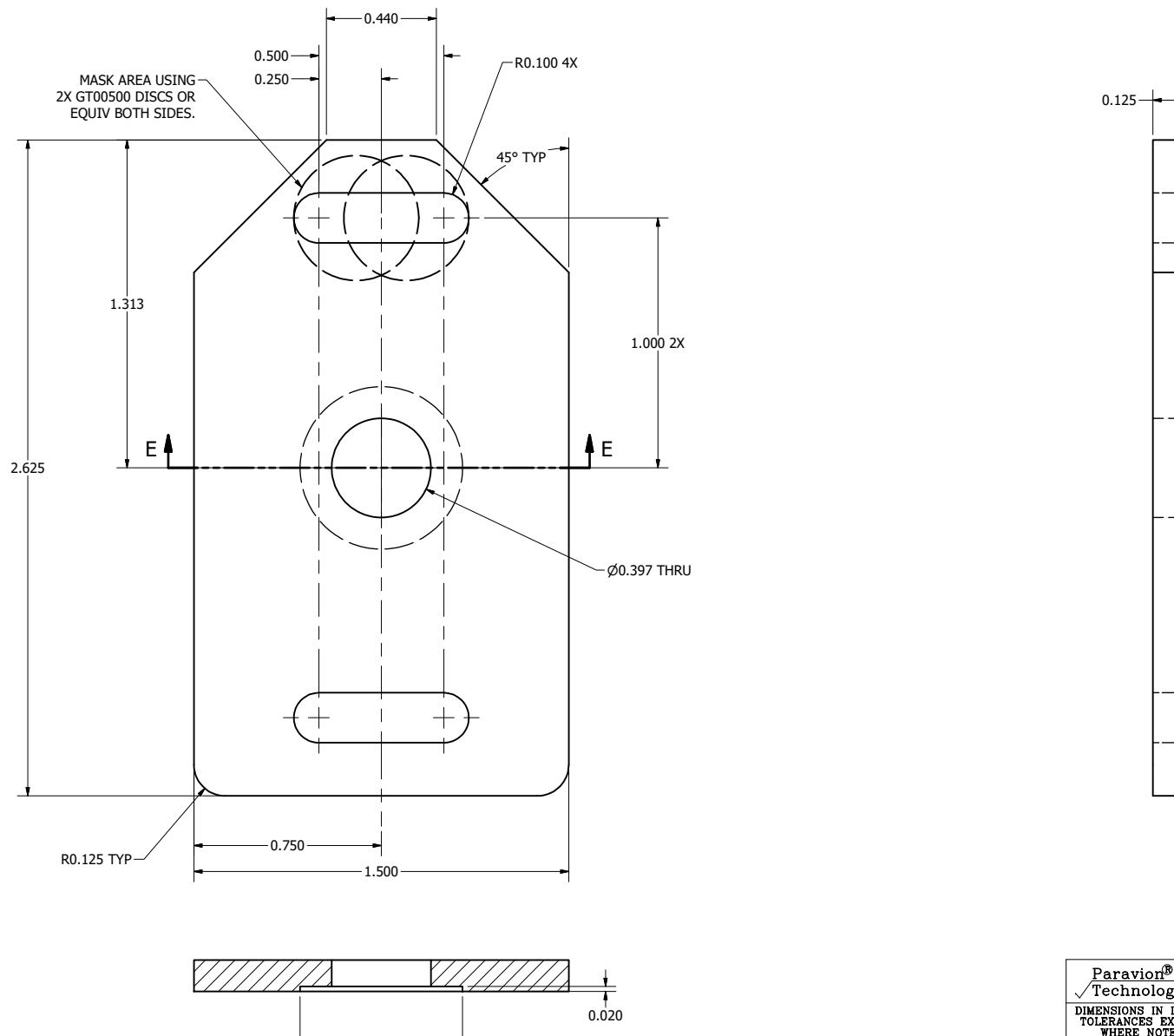
-21 BASE

MATERIAL: 6061-T651, AMS 4025, AMS 4027, AMS-QQ-A-250/11

STOCK SIZE: 0.125" THK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2

COLOR: BLACK



BREAK ALL SHARP EDGES

SECTION E-E

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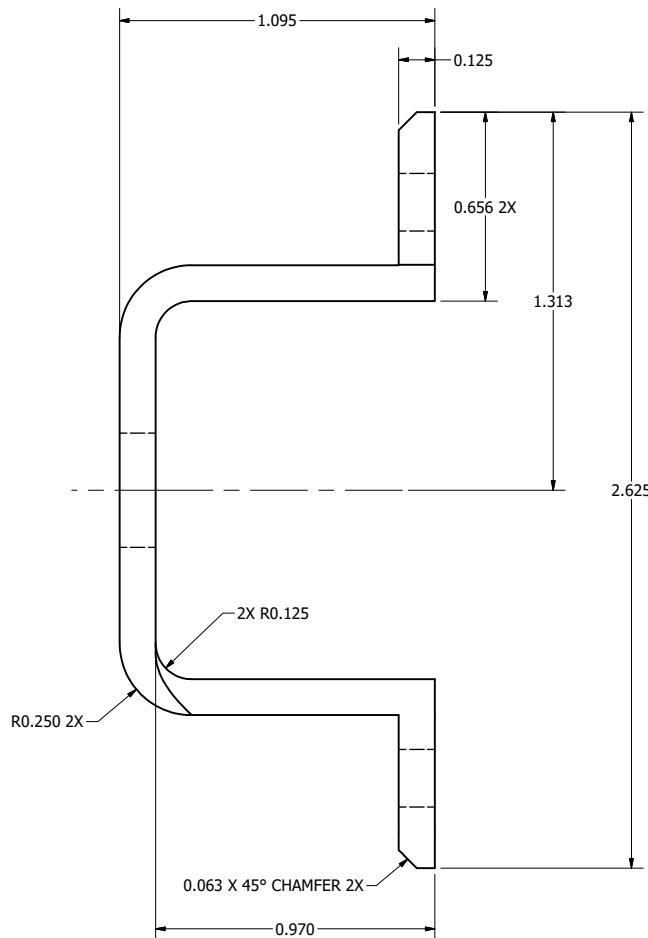
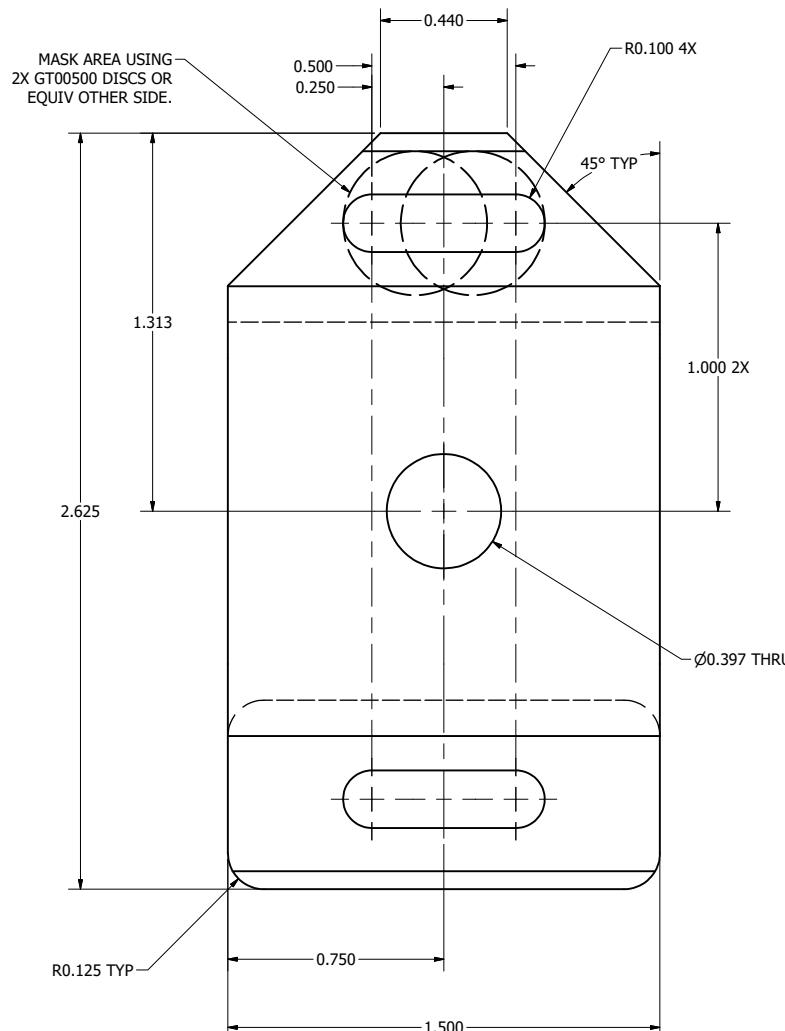
PROTO

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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY		CHK'D BY	APPVD. BY
.X = ±.1		KEW	LS	NLH	7/8/16
.XX = ±.05					
.XXX = ±.010					
ANGLES = ± 1°					
THREADS: INTERNAL: CLASS 2B	DO NOT SCALE DRAWING				
EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	© 2021 PARAVION TECH, INC.			
		PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			

27 OF 66

-22 BRACKET

MATERIAL: 6061-T651, AMS 4128, AMS-QQ-A-225/8
STOCK SIZE: 1.50" X 1.500" X 3.00" BAR OR EQUIV.
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
COLOR: BLACK



BREAK ALL SHARP EDGES

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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
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.X = ±.1	.XX = ±.05	KEW	LS	NLH	7/8/16
.XXX = ±.010	ANGLES = ± 1°	DO NOT SCALE DRAWING			
3RD ANGLE PROJECTION					SHEET
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-23 LATERAL MOUNT

MATERIAL: 6061-T6, AMS 4150, AMS 4173, AMS-QQ-A-200/8
 STOCK SIZE: 0.125" THK EXTRUDED ANGLE
 FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
 COLOR: BLACK

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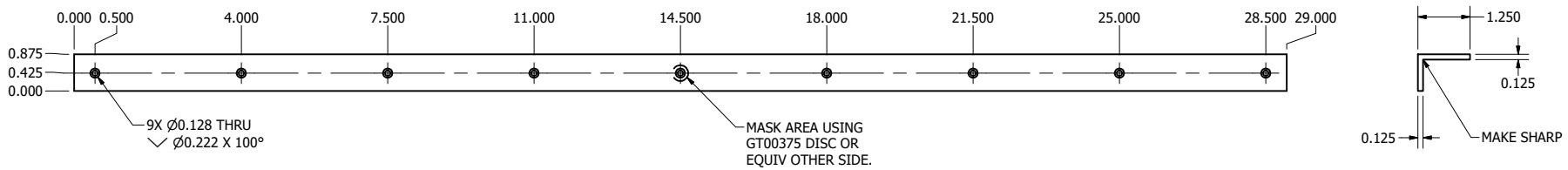
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**BREAK ALL SHARP EDGES**

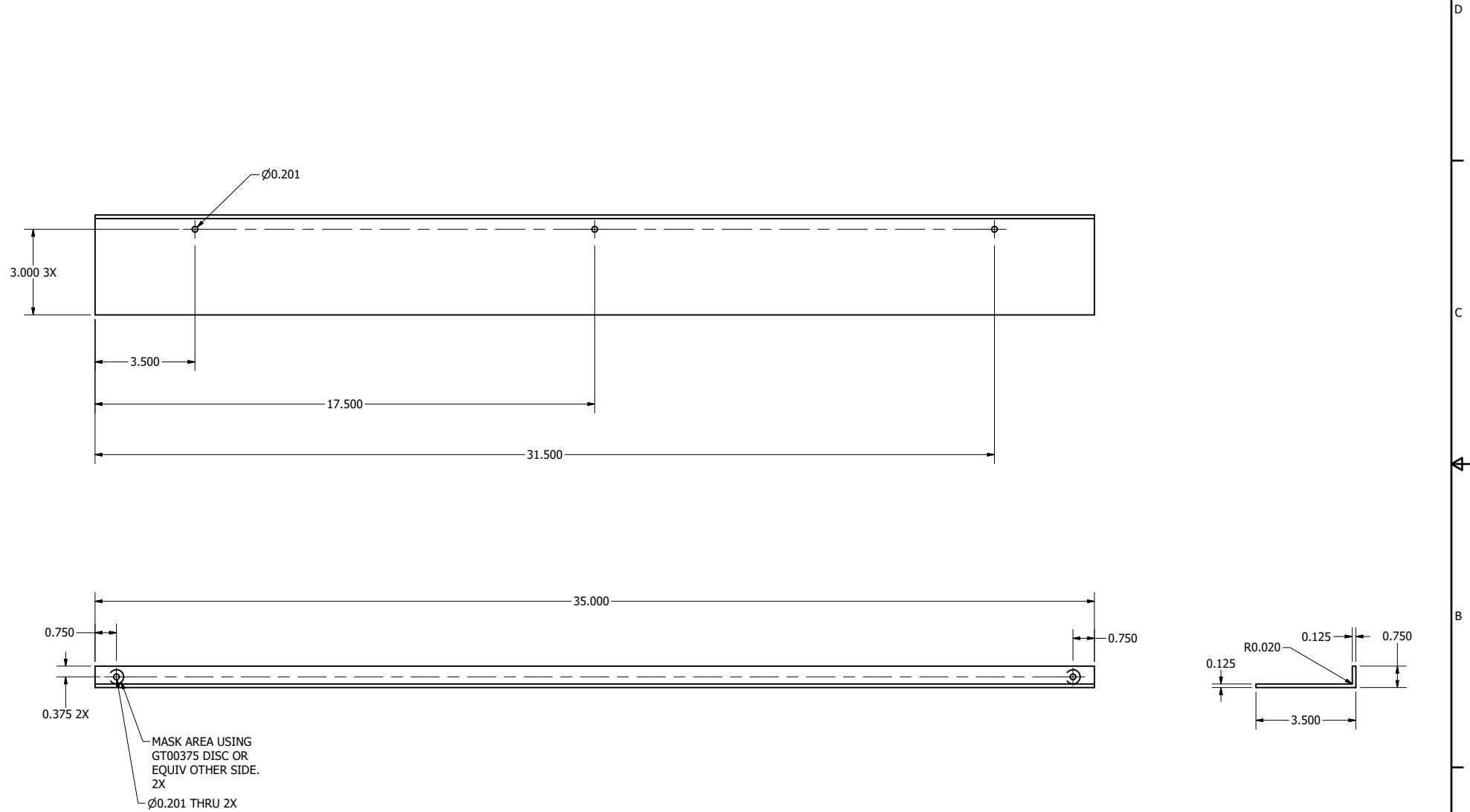
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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
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.X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		KEW	LS	NLH	7/8/16
					G
DO NOT SCALE DRAWING		3RD ANGLE PROJECTION		SHEET 29 OF 66	
INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			

-25 LONG MOUNT

MATERIAL: 6061-T6, AMS 4150, AMS 4173, AMS-QQ-A-200/8
STOCK SIZE: 0.125" THK EXTRUDED ANGLE
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
COLOR: BLACK



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Paravion® Inc.		TITLE		DRAWING NUMBER			
Technology		R/T POD DOOR ASSEMBLY		C208RT-2000			
DIMENSIONS IN INCHES		TOLERANCES EXCEPT					
DRAWN BY	CHK'D BY	APPROVED BY	DATE	REV	ECO		
KEW	LS	NLH	7/8/16	G			
WHERE NOTED:							
.X = ±.1							
.XX = ±.05							
.XXX = ±.010							
ANGLES = ± 1°							
THREADS:							
INTERNAL: CLASS 2B							
EXTERNAL: CLASS 2A							
3RD ANGLE PROJECTION		DO NOT SCALE DRAWING		SHEET			
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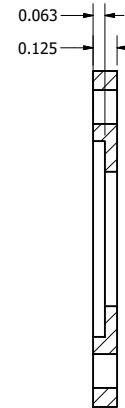
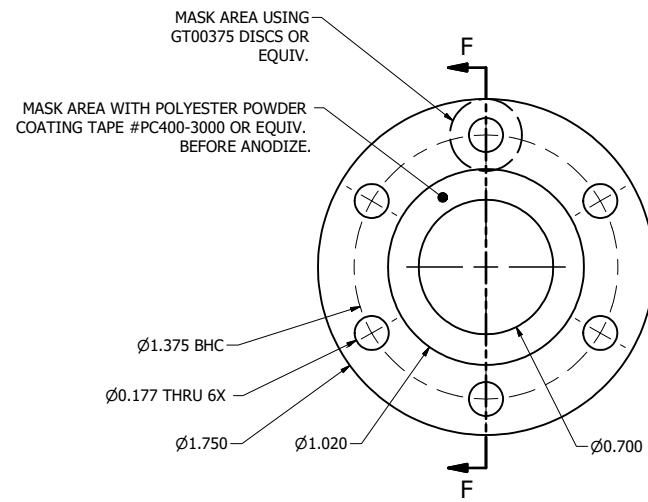
-26 BEARING RETAINER

MATERIAL: 6061-T651, AMS 4025, AMS 4115, AMS 4116, AMS 4117 AMS 4027, AMS-QQ-A-250/11

STOCK SIZE: 0.125" THK SHEET OR Ø 2.000" ROD

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2

COLOR: BLACK

**BREAK ALL SHARP EDGES**

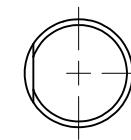
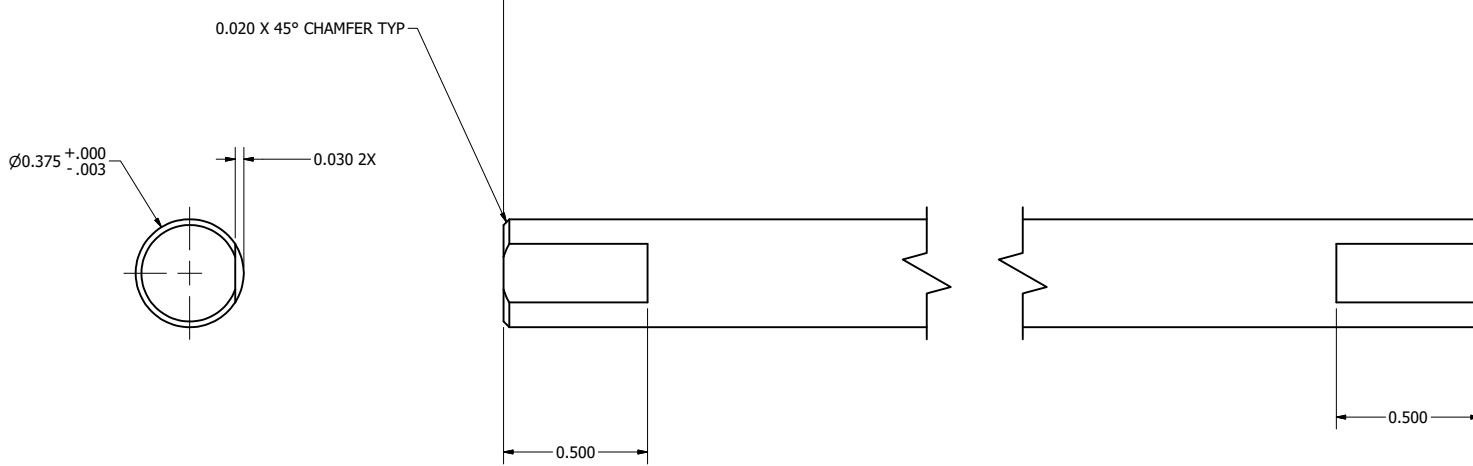
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Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES		TOLERANCES EXCEPT			
WHERE NOTED:		.X = ± .1			
		.XX = ± .05			
		.XXX = ± .010			
		ANGLES = ± 1°			
THREADS:		DO NOT SCALE DRAWING		SHEET	
INTERNAL: CLASS 2B		© 2021 PARAVION TECH, INC.		31 OF 66	
EXTERNAL: CLASS 2A		PARAVION IS A TRADEMARK OF			
3RD ANGLE PROJECTION		PARAVION TECHNOLOGY INC.			

-27 SECONDARY SHAFT

MATERIAL: 304 S.S. BAR PER AMS 5639
STOCK SIZE: Ø 0.375" (+.000"/-.003") ROD TGP
FINISH: NONE



BREAK ALL SHARP EDGES

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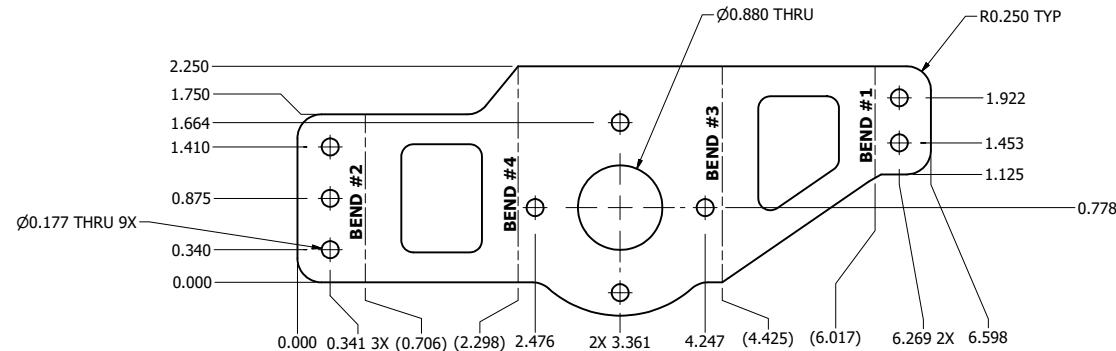
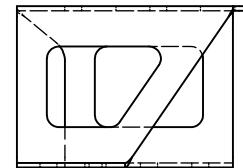
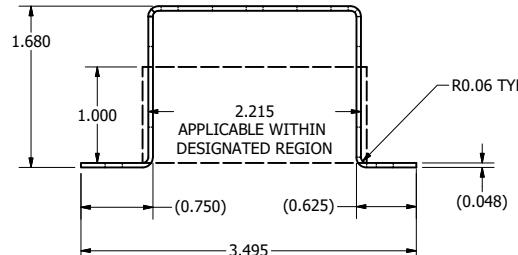
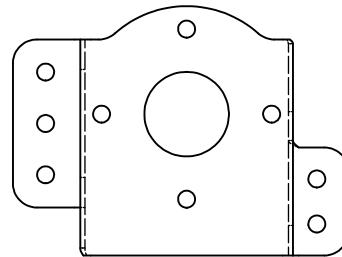
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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
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.X = ±.1		KEW	LS	NLH	7/8/16
.XX = ±.05					
.XXX = ±.010					
ANGLES = ± 1°					
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A					DO NOT SCALE DRAWING
3RD ANGLE PROJECTION					32 OF 66
© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.					SHEET

-29 MOTOR MOUNT

MATERIAL: 304 S.S. AMS 5517
 STOCK SIZE: 18GA (0.0475") THK SHEET
 FINISH: NONE

	BEND CHART			
	BEND #1	BEND #2	BEND #3	BEND #4
PUNCH	#21	#21	#21	#21
DIE	#2	#2	#2	#2
ANGLE	91	91	91	91
DIMENSION	.586	.711	1.64	1.64

**FLAT PATTERN**

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PROTO

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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: $.X = \pm .1$ $.XX = \pm .05$ $.XXX = \pm .010$ $ANGLES = \pm 1^\circ$		DRAWN BY	CHK'D BY	APRV'D. BY	DATE
		KEW	LS	NLH	7/8/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING		REV ECO	
				G	
3RD ANGLE PROJECTION		© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		SHEET	
				34 OF 66	

-30 BRACKET

MATERIAL: 6061-T6, AMS 4150, AMS 4173, AMS-QQ-A-200/8
 STOCK SIZE: 0.125" THK EXTRUDED ANGLE
 FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
 COLOR: BLACK

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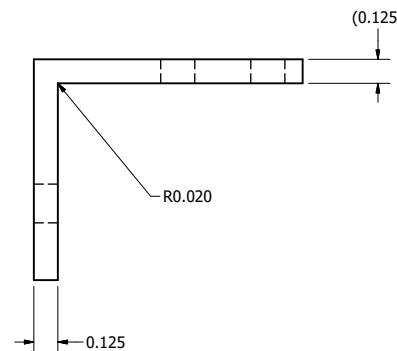
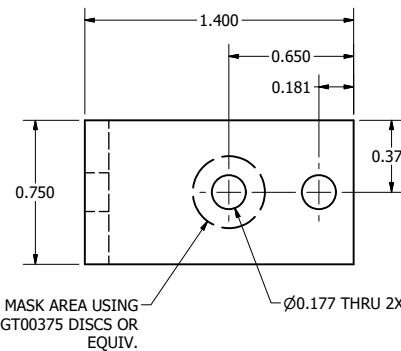
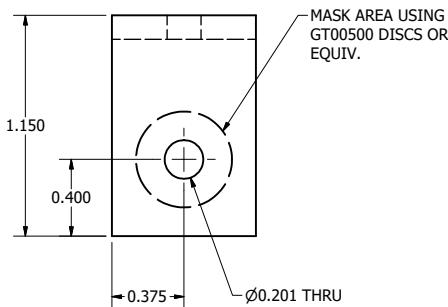
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PROTO

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Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
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.X = ± .1		KEW	LS	NLH	7/8/16
.XX = ± .05					
.XXX = ± .010					
ANGLES = ± 1°					
DO NOT SCALE DRAWING					SHEET
3RD ANGLE PROJECTION					35 OF 66

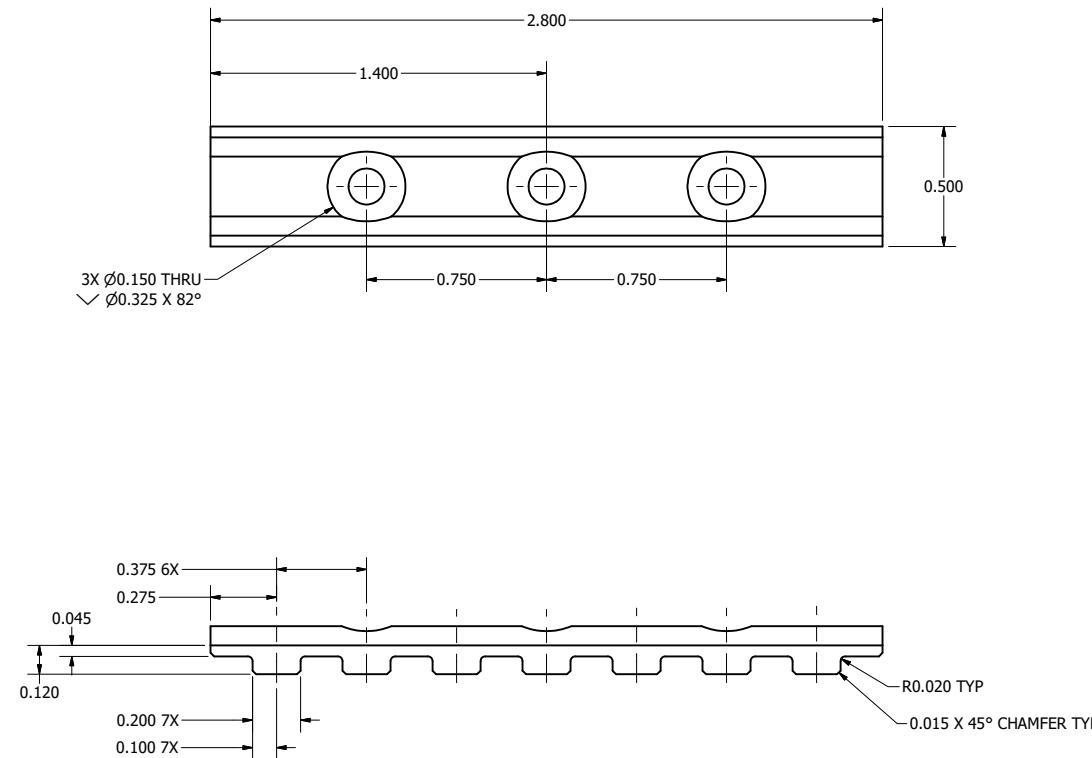
-31 BELT CLIP

MATERIAL: 6061-T651, AMS 4025, AMS 4027, AMS-QQ-A-250/11

STOCK SIZE: 0.500" X 0.50" X 3.00"

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2

COLOR: BLACK



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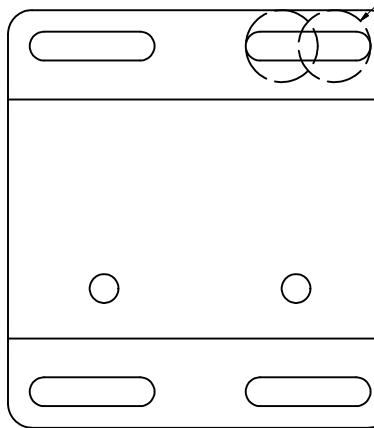
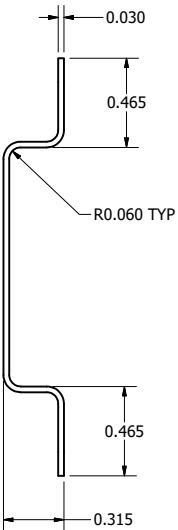
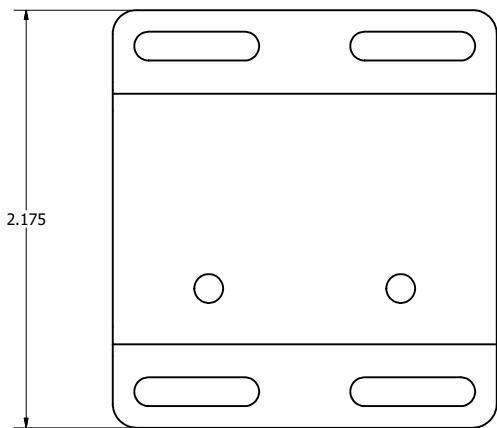
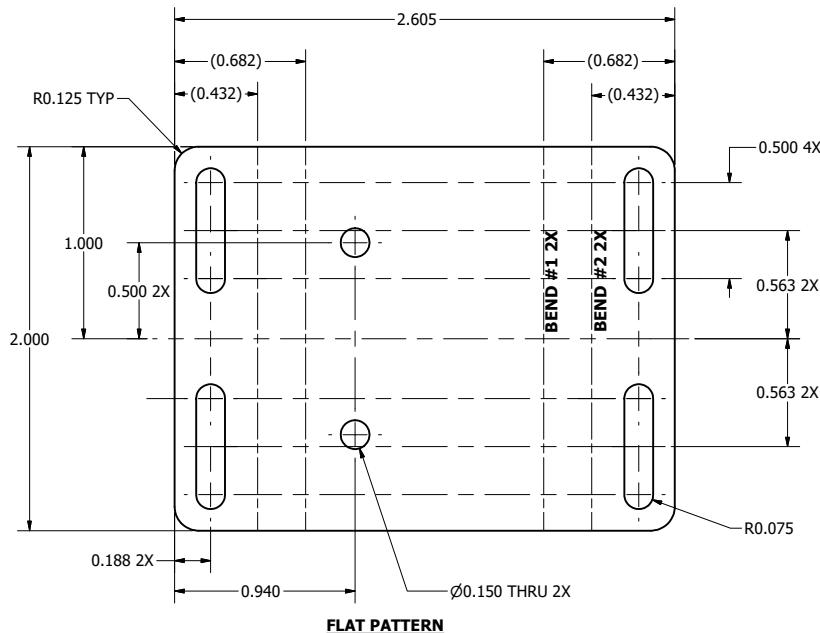
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Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY	CHK'D BY	APPROVED BY	DATE
.X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		KEW	LS	NLH	7/8/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		3RD ANGLE PROJECTION	DO NOT SCALE DRAWING		SHEET
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-32 SWITCH BRACKET

MATERIAL: 6061-T6,AMS 4025, AMS 4027, AMS-QQ-A-250/11
STOCK SIZE: 0.030" THK SHEET
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
COLOR: BLACK

BEND CHART		
	BEND #1	BEND #2
PUNCH	#6	#6
DIE	#4	#4
ANGLE	54	54
DIMENSION	.465	.250



BREAK ALL SHARP EDGES

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BBOTO

PROTO

1

11 of 11

Paravion®
Technology

Paravion® Technology Inc.	TITLE	DRAWING NUMBER
	R/T POD DOOR ASSEMBLY	C208RT-2000

ASSEMBLY					
DRAWN BY	CHK'D BY	APRVD. BY	DATE	REV	ECO

.X = $\pm .1$	KEW	LS	NLH	7/8/16	G	
.XX = $\pm .05$						
.XXX = $\pm .010$						

ANGLES: $\pm 1^\circ$ DO NOT SCALE DRAWING SHEET
THREADS:
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A
3RD ANGLE PROJECTION
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37 OF 66

EXTERNAL CLASS SA PROJECTION PARAVION TECHNOLOGY INC. 1

-33 SHAFT SPACER

MATERIAL: 6061-T651, AMS 4128, AMS-QQ-A-225/8
STOCK SIZE: Ø .500" X .375"
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
COLOR: BLACK



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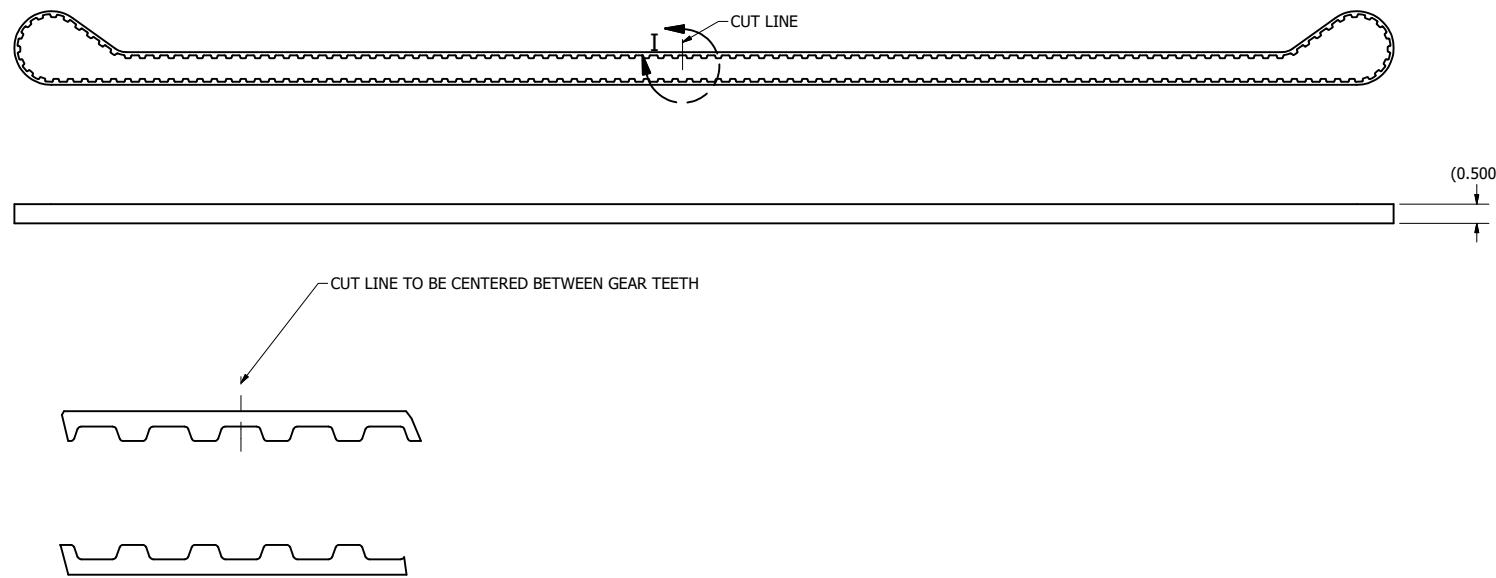
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Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DRAWN BY	CHK'D BY	APPROVED BY	DATE	REV	ECO
KEW	LS	NLH	7/8/16	G	
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-34 BELT

MAKE FROM: ES10050-1
CUT LENGTH: 74.250" +/- 0.060"



DETAIL I

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.X = +/- .1		KEW	LS	NLH	7/8/16
.XX = +/- .05					
.XXX = +/- .010					
ANGLES = +/- 1°					
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING		SHEET	
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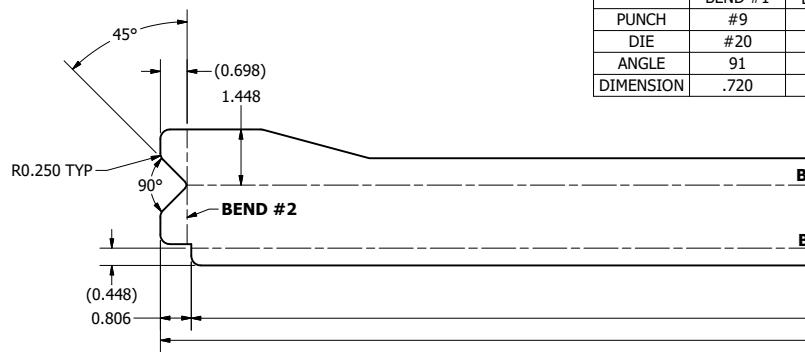
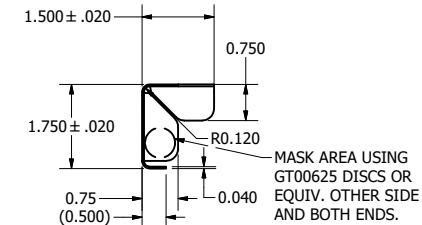
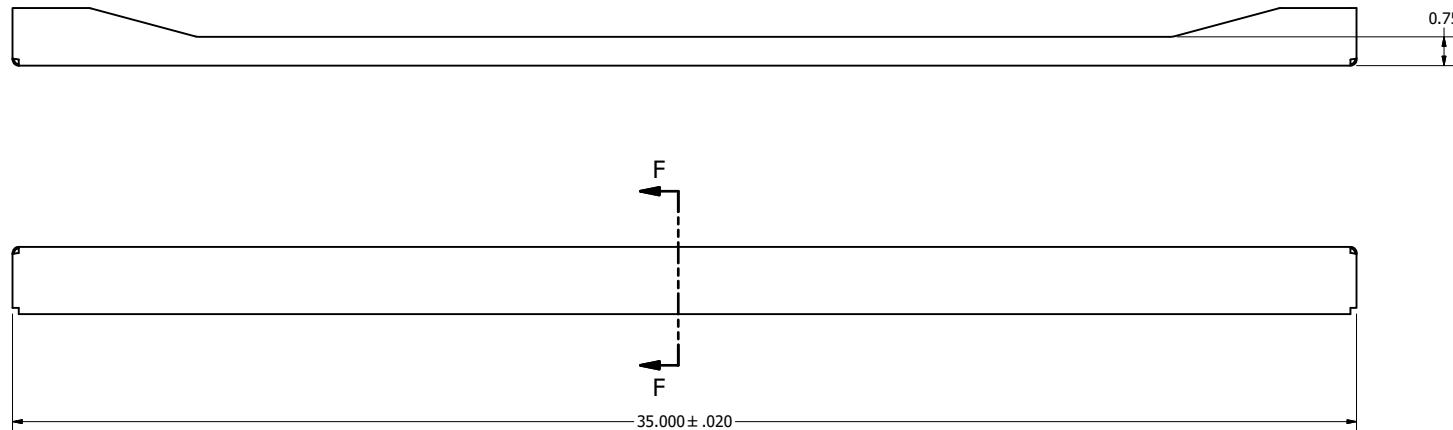
-35 SUPPORT

MATERIAL: 6061-T6, AMS 4025, AMS 4027, AMS-QQ-A-250/11

STOCK SIZE: 0.040" THK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2

COLOR: BLACK

**BEND #4****BEND #3****FLAT PATTERN****SECTION F-F****BREAK ALL SHARP EDGES**

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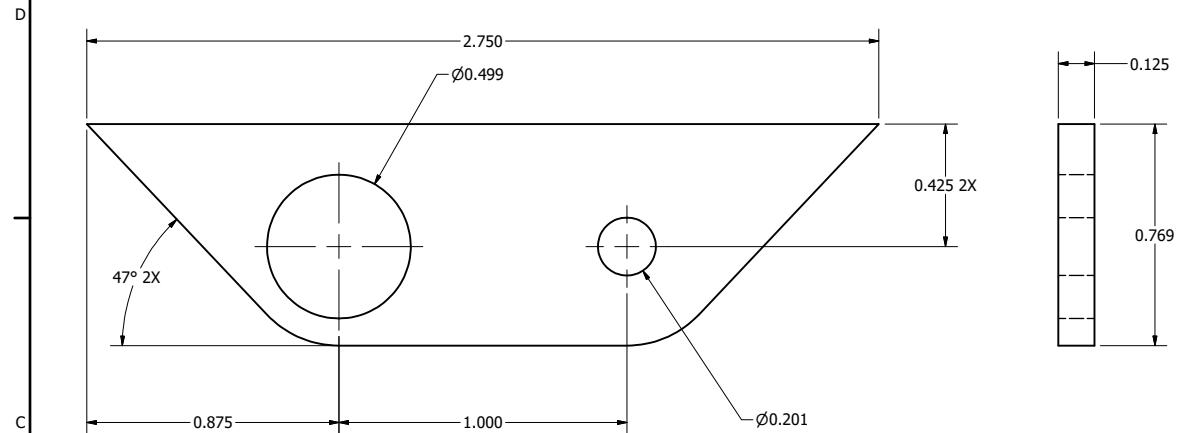
PROTO

Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY NLH	DATE 7/8/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		REV G	ECO		
3RD ANGLE PROJECTION		DO NOT SCALE DRAWING © 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.			

SHEET
40 OF 66

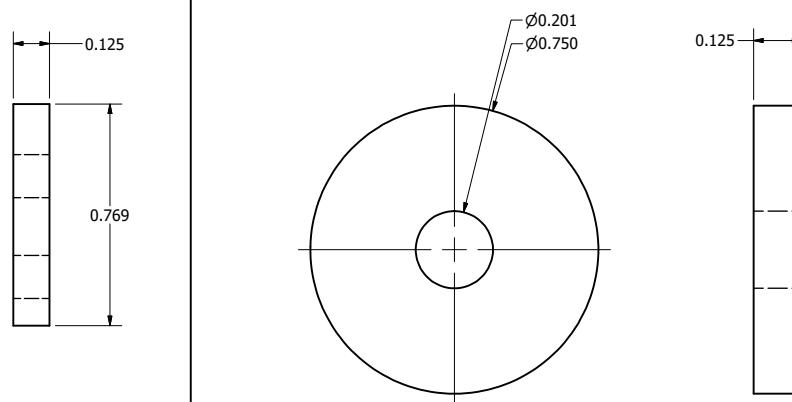
-37 TEFLO SPACER

MATERIAL: PTFE G400
FINISH: NONE
COLOR: WHITE



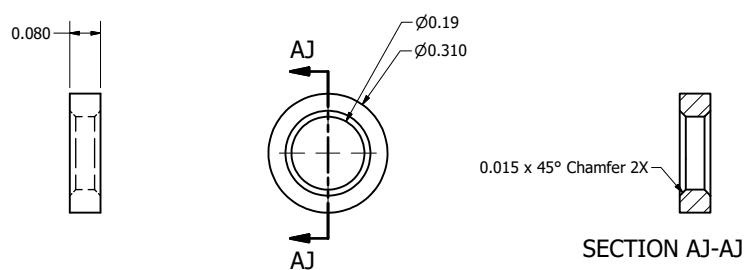
-38 TEFLO SPACER

MATERIAL: PTFE G400
FINISH: NONE
COLOR: WHITE



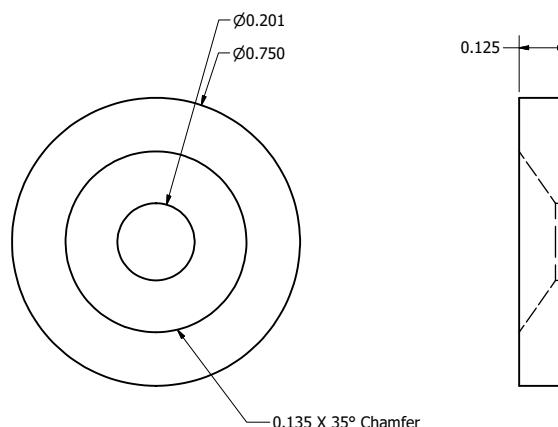
-39 BUSHING

MATERIAL: 300 SERIES S.S. BAR, PLATE OR SHEET PER AMS 5639, 5513, 5648 OR 5524
FINISH: NONE



-54 TEFLO SPACER

MATERIAL: PTFE G400
FINISH: NONE
COLOR: WHITE



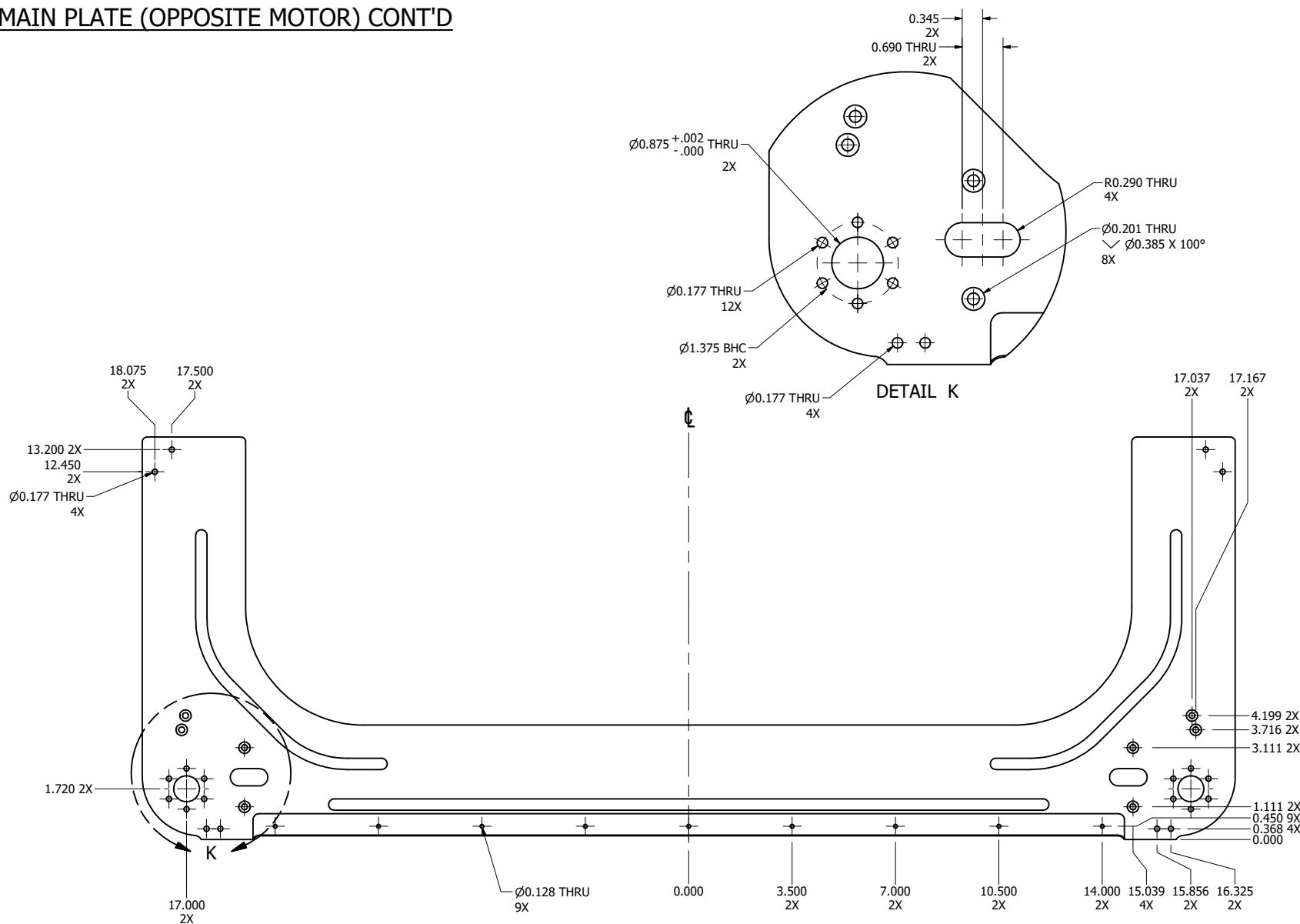
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Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY NLH	DATE 7/8/16
3RD ANGLE PROJECTION	DO NOT SCALE DRAWING	REV G			
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41 OF 66

-40 MAIN PLATE (OPPOSITE MOTOR) CONT'D



Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16
.X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°				REV G	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	DO NOT SCALE DRAWING		SHEET 43 OF 66	
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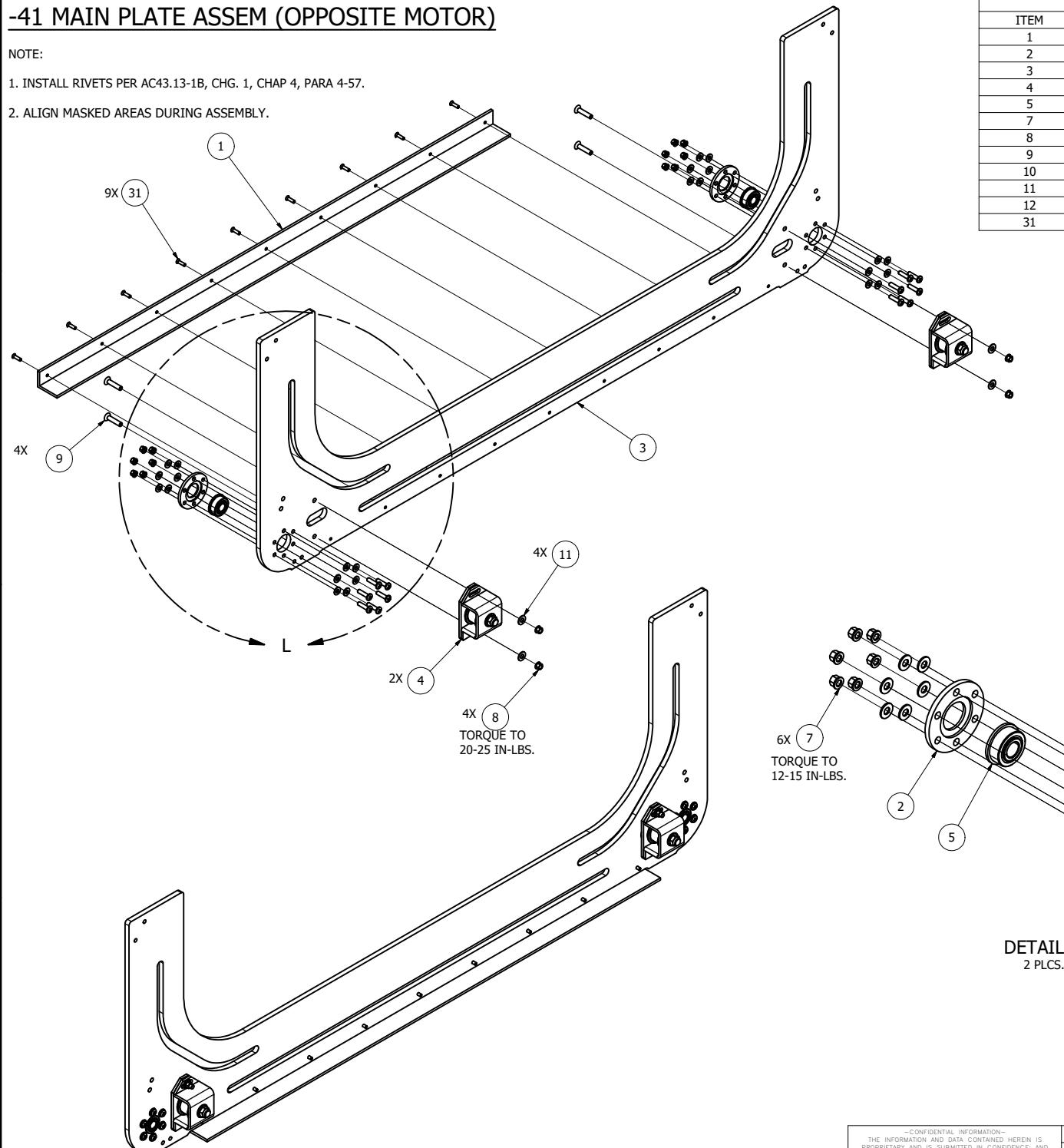
PROTO

-41 MAIN PLATE ASSEM (OPPOSITE MOTOR)

NOTE:

1. INSTALL RIVETS PER AC43.13-1B, CHG. 1, CHAP 4, PARA 4-57.

D 2. ALIGN MASKED AREAS DURING ASSEMBLY.

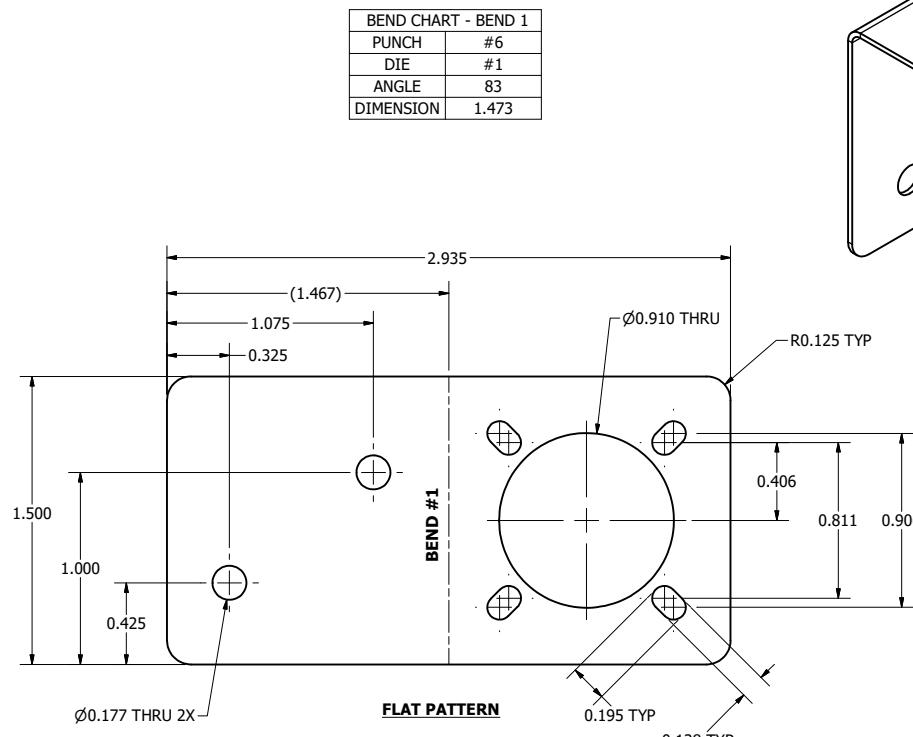
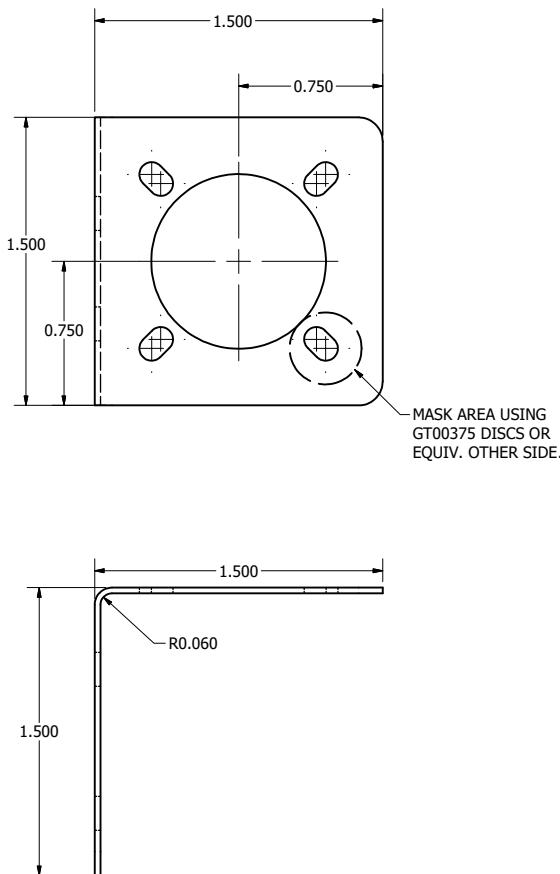


PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	C208RT-2000-23	LATERAL MOUNT
2	2	C208RT-2000-26	BEARING RETAINER
3	1	C208RT-2000-40	MAIN PLATE (OPPOSITE MOTOR)
4	2	C208RT-2000-6	IDLER PULLEY ASSEM
5	2	ES39516-3	FLANGED BEARING
7	12	MS21042L08	NUT
8	4	MS21042L3	NUT
9	4	MS24693S275	SCREW
10	12	MS27039-0810	SCREW
11	4	NAS1149D0332J	WASHER
12	24	NAS1149DN832J	WASHER
31	9	MS20426AD4-7	RIVET

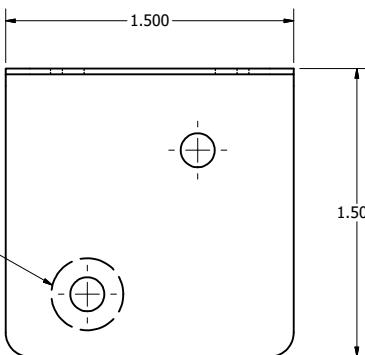
Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPRVD. BY NLH	DATE 7/8/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		REV G	ECO		
DO NOT SCALE DRAWING © 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		3RD ANGLE PROJECTION		SHEET 44 OF 66	

-43 CONNECTOR MOUNT

MATERIAL: 6061-T6, AMS 4025, AMS 4027, AMS-QQ-A-250/11
 STOCK SIZE: 0.030" THK SHEET
 FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
 COLOR: BLACK



MASK AREA USING
GT00375 DISCS OR
EQUIV. OTHER SIDE



BREAK ALL SHARP EDGES

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Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	DO NOT SCALE DRAWING © 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.	3RD ANGLE PROJECTION			REV G ECO
45 OF 66					SHEET

-46 COVER

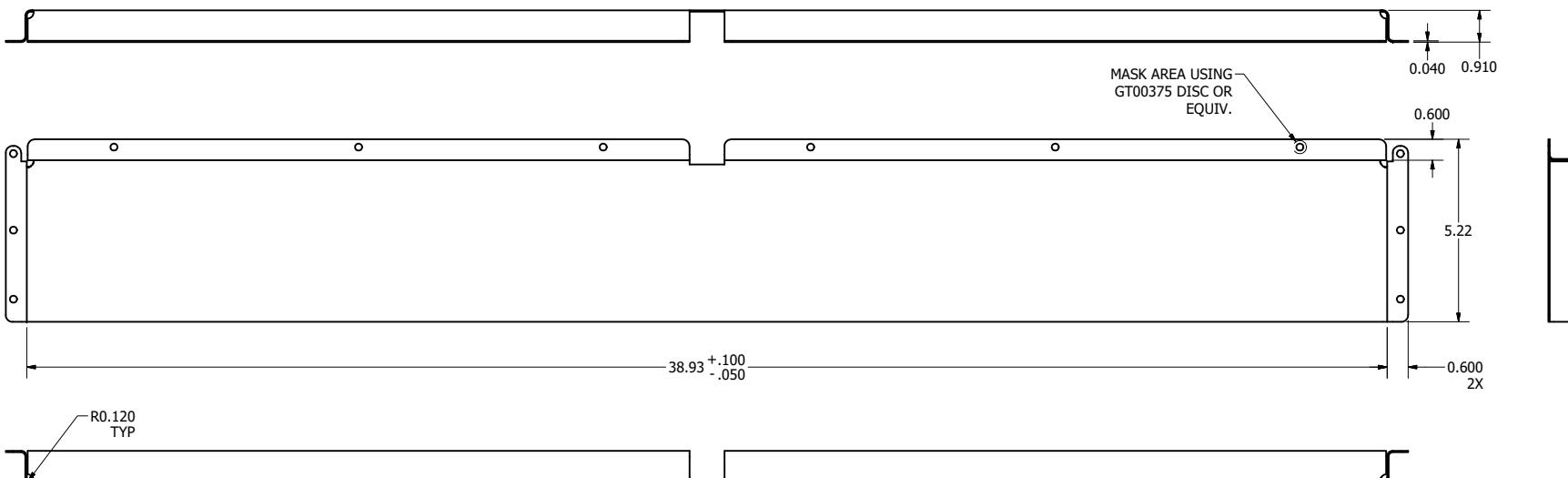
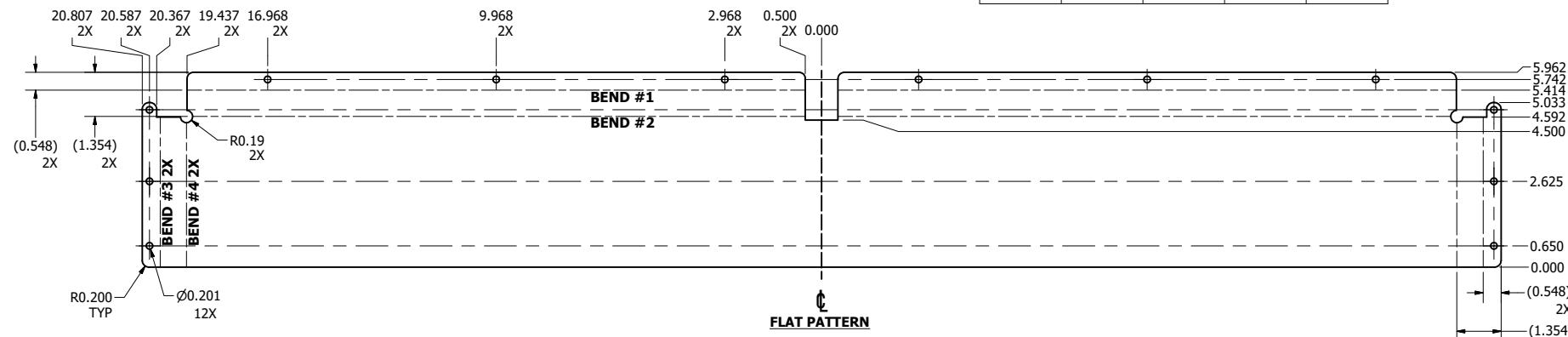
MATERIAL: 6061-T6, AMS 4025, AMS 4027, AMS-QQ-A-250/11

STOCK SIZE: 0.040" THK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

OPTIONAL FINISH: BLACK POLYURETHANE POWDER COAT CARDINAL C241-BK303

	BEND CHART			
	BEND #1	BEND #2	BEND #3	BEND #4
PUNCH	#9	#9	#9	#9
DIE	#1	#15	#1	#15
ANGLE	77	62	78	62
DIMENSION	.548	.882	.548	.882



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PROTO

Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES		DRAWN BY		CHK'D BY	
WHERE NOTED:		BY	BY	APPROVED	DATE
.X = ±.1		KEW	LS	NLH	7/8/16
.XX = ±.05					
.XXX = ±.010					
ANGLES = ± 1°					
DO NOT SCALE DRAWING		REV		ECO	
THREADS:					
INTERNAL: CLASS 2B					
EXTERNAL: CLASS 2A					
3RD ANGLE PROJECTION		G		SHEET	
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-75 DOOR A

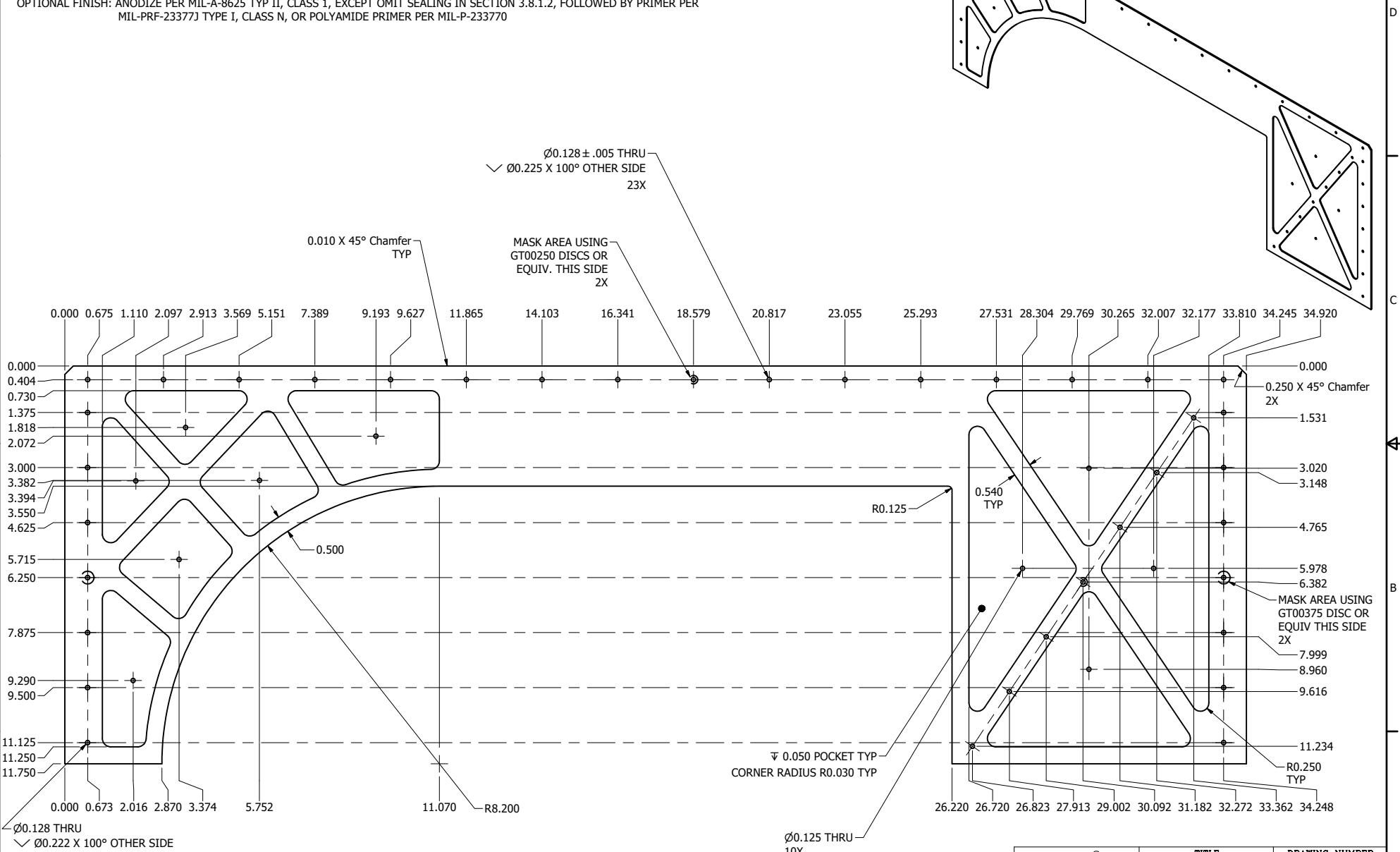
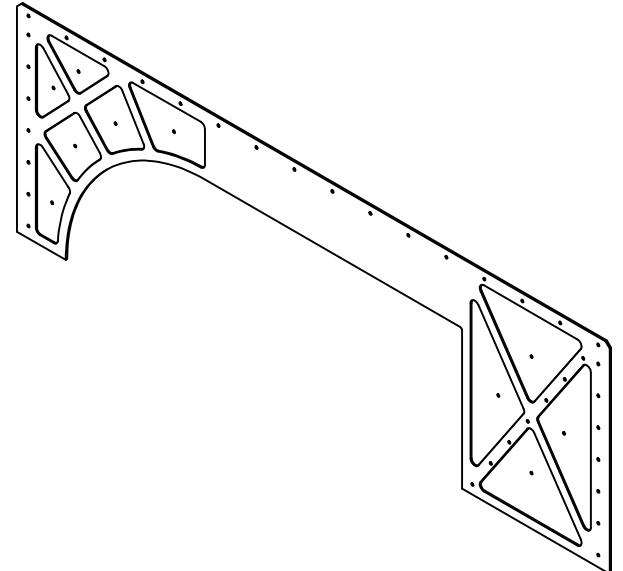
MATERIAL: 7075-T76 OR T62 PER AMS 4045, AMS 4049, AMS-QQ-A-250/12, AMS-QQ-A-250/13, AMS-QQ-A-250/24, AMS-QQ-A-250/25

STOCK SIZE: 0.080" THK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

OPTIONAL FINISH: BLACK POLYURETHANE POWDER COAT CARDINAL C241-BK303

OPTIONAL FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2, FOLLOWED BY PRIMER PER MIL-PRF-23377J TYPE I, CLASS N, OR POLYAMIDE PRIMER PER MIL-P-233770



Paravion® Technology		TITLE		DRAWING NUMBER	
R/T POD DOOR ASSEMBLY		C208RT-2000			
DIMENSIONS IN INCHES		DRAWN BY		APPROVED BY	
✓		KEW	LS	NLH	7/8/16
PROT0					
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THREADS:		3RD ANGLE PROJECTION			
INTERNAL: CLASS 2B					
EXTERNAL: CLASS 2A					

-76 DOOR B

MATERIAL: 7075-T76 OR T62 PER AMS 4045, AMS 4049, AMS-QQ-A-250/12, AMS-QQ-A-250/13, AMS-QQ-A-250/24, AMS-QQ-A-250/25

STOCK SIZE: 0.080" THK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

OPTIONAL FINISH: BLACK POLYURETHANE POWDER COAT CARDINAL C241-BK303

OPTIONAL FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2, FOLLOWED BY PRIMER PER MIL-PRF-23377J TYPE I, CLASS N, OR POLYAMIDE PRIMER PER MIL-P-233770

D

D

C

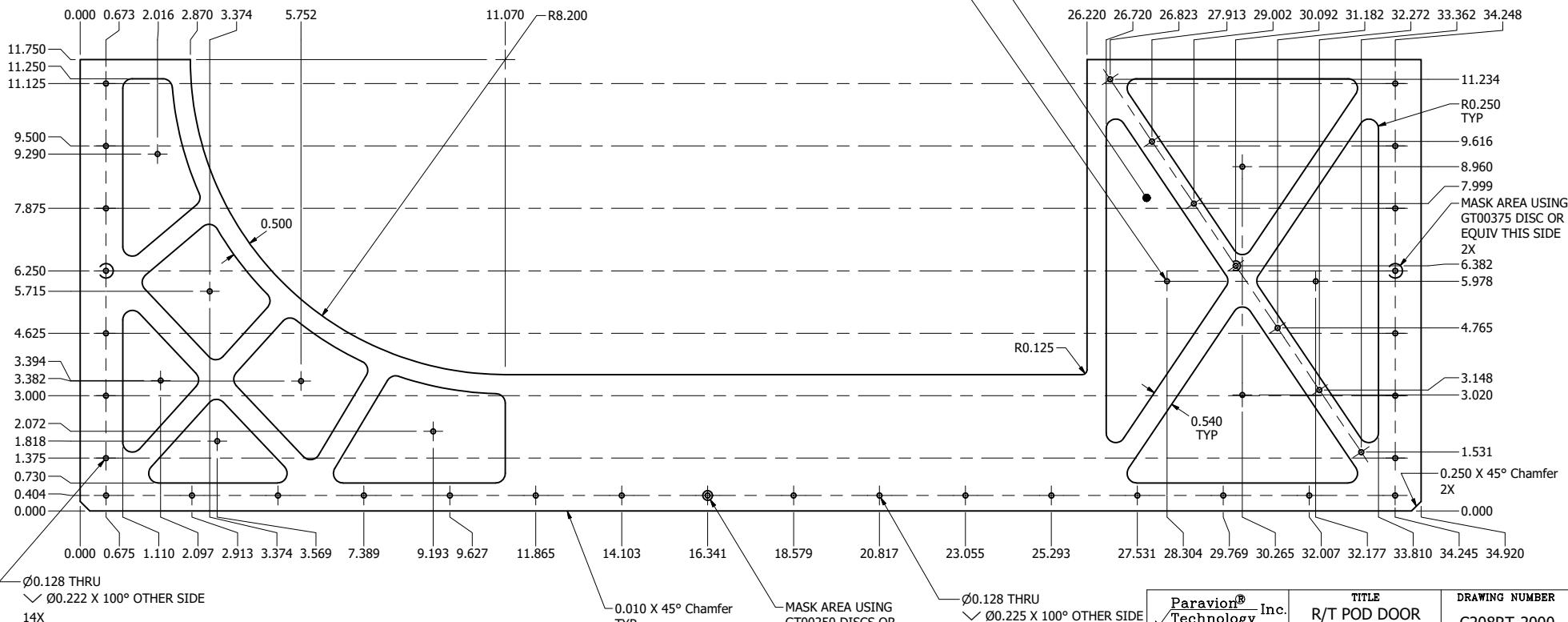
C

B

B

A

A



Paravion® Technology Inc.		TITLE		DRAWING NUMBER	
R/T POD DOOR ASSEMBLY		C208RT-2000			
DRAWN BY	CHK'D BY	APPROVED BY	DATE	REV	ECO
			7/8/16		G
KEW	LS	NLH			

DO NOT SCALE DRAWING

THREADS:
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

3RD ANGLE PROJECTION

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PROTO

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1

-77 DOOR C

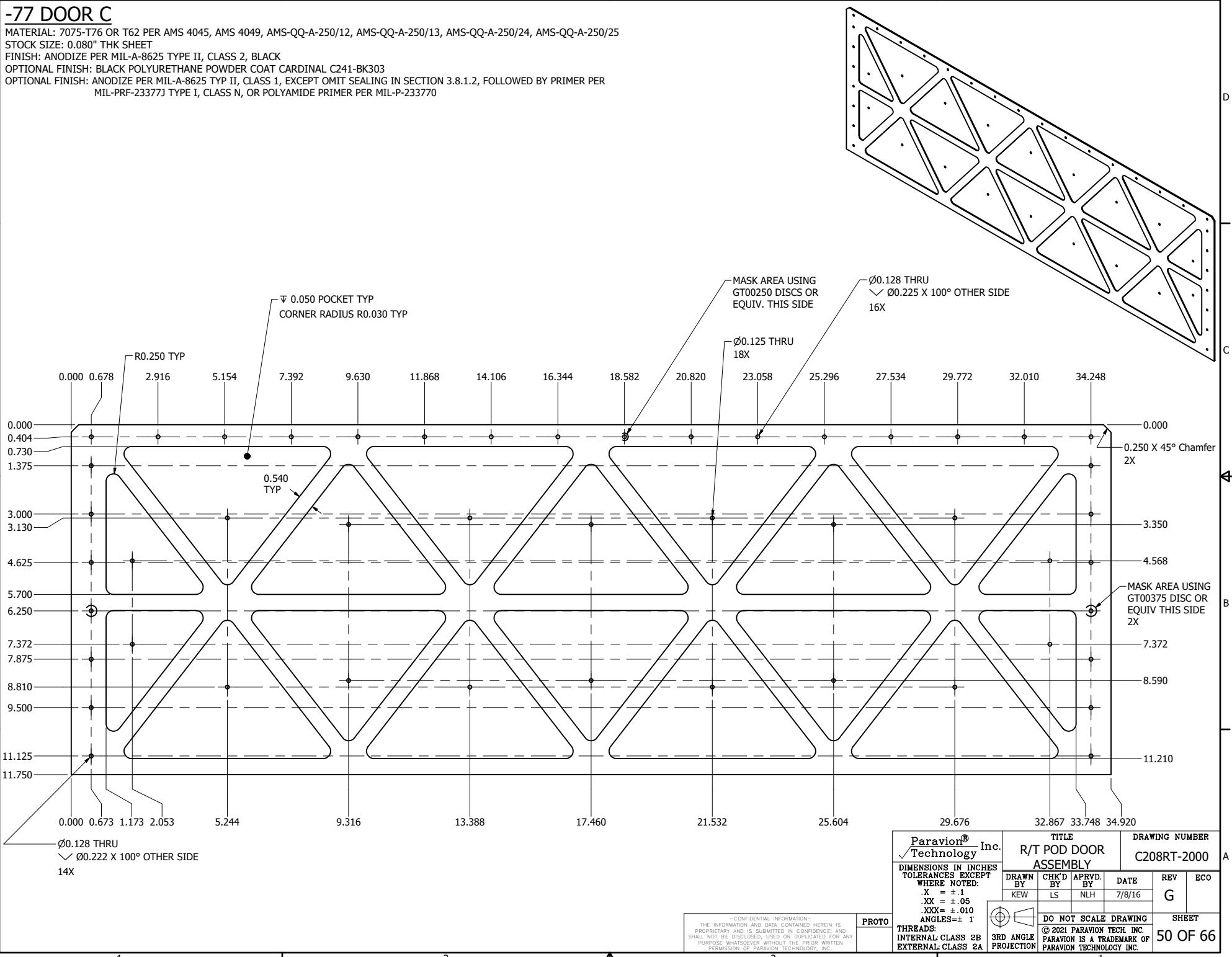
MATERIAL: 7075-T76 OR T62 PER AMS 4045, AMS 4049, AMS-QQ-A-250/12, AMS-QQ-A-250/13, AMS-QQ-A-250/24, AMS-QQ-A-250/25

STOCK SIZE: 0.080" THK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

OPTIONAL FINISH: BLACK POLYURETHANE POWDER COAT CARDINAL C241-BK303

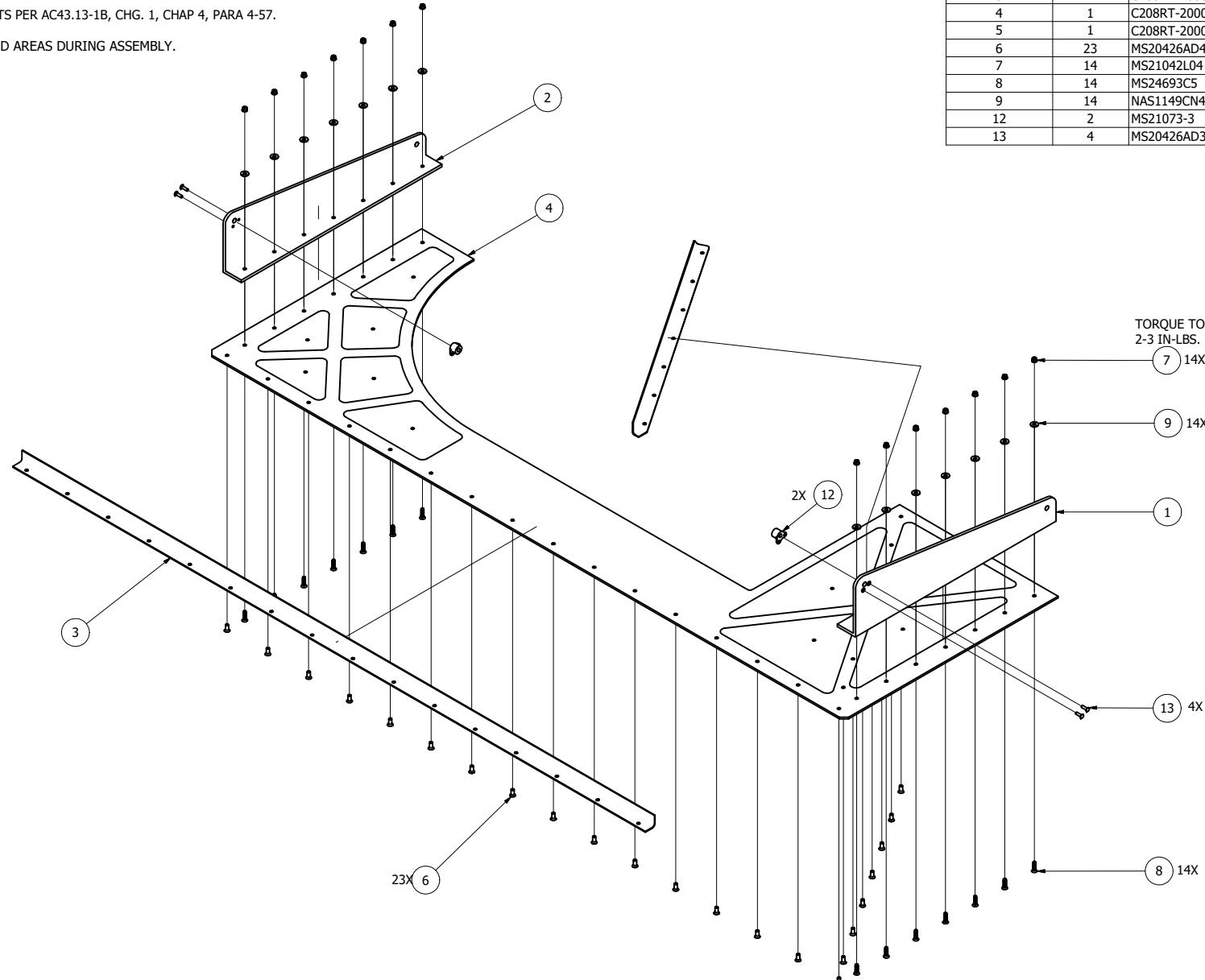
OPTIONAL FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2, FOLLOWED BY PRIMER PER MIL-PRF-23377J TYPE I, CLASS N, OR POLYAMIDE PRIMER PER MIL-P-233770



-79 DOOR ASSEM B

NOTE:

1. INSTALL RIVETS PER AC43.13-1B, CHG. 1, CHAP 4, PARA 4-57.
2. ALIGN MASKED AREAS DURING ASSEMBLY.



Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY			DRAWING NUMBER C208RT-2000		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16	REV G	ECO
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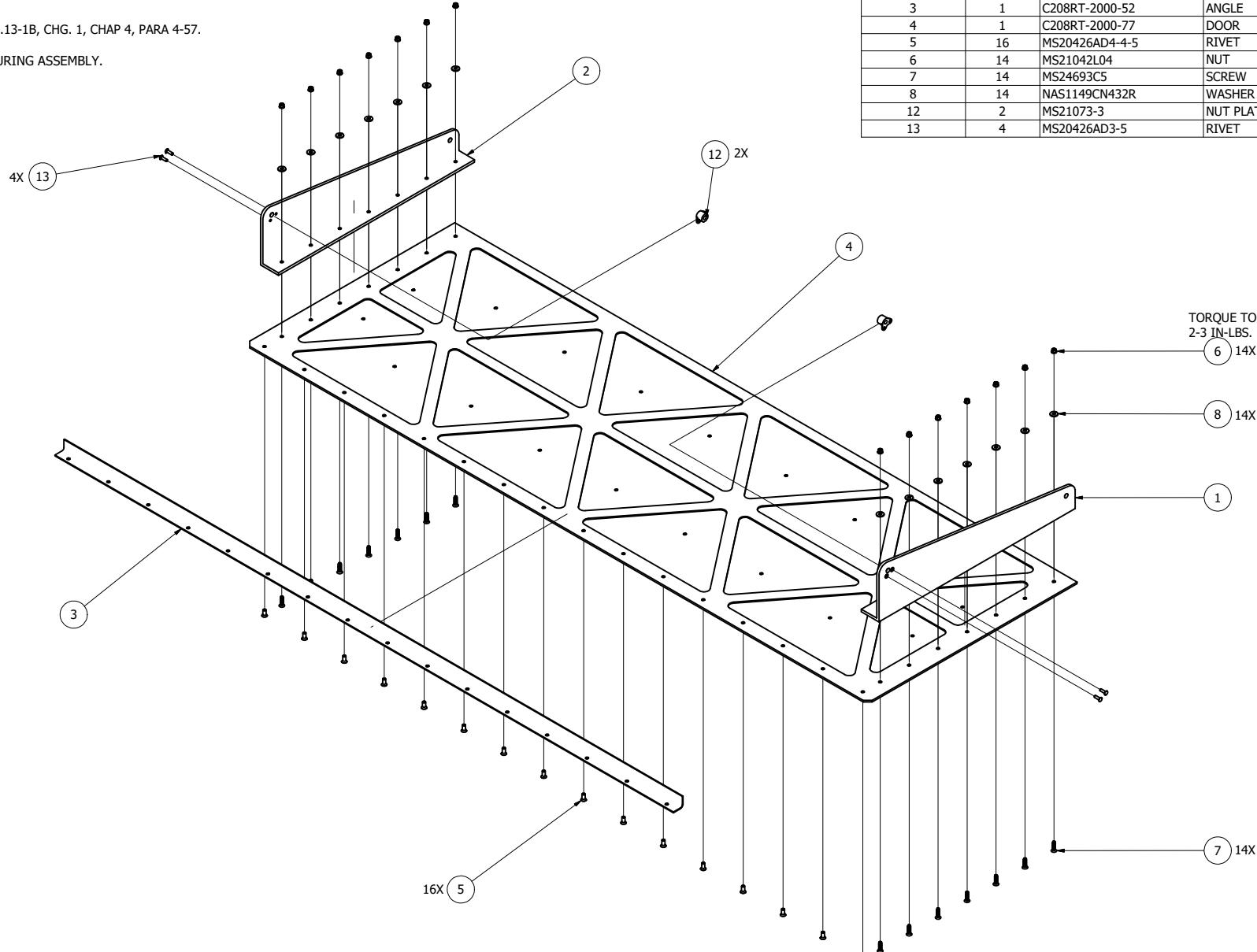
PROTO

52 OF 66

-80 DOOR ASSEM C

NOTE:

1. INSTALL RIVETS PER AC43.13-1B, CHG. 1, CHAP 4, PARA 4-57.
2. ALIGN MASKED AREAS DURING ASSEMBLY.



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	C208RT-2000-15	BRACKET
2	1	C208RT-2000-16	BRACKET
3	1	C208RT-2000-52	ANGLE
4	1	C208RT-2000-77	DOOR
5	16	MS20426AD4-4-5	RIVET
6	14	MS21042L04	NUT
7	14	MS24693C5	SCREW
8	14	NAS1149CN432R	WASHER
12	2	MS21073-3	NUT PLATE, LOCKING
13	4	MS20426AD3-5	RIVET

Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
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THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		REV G	ECO		
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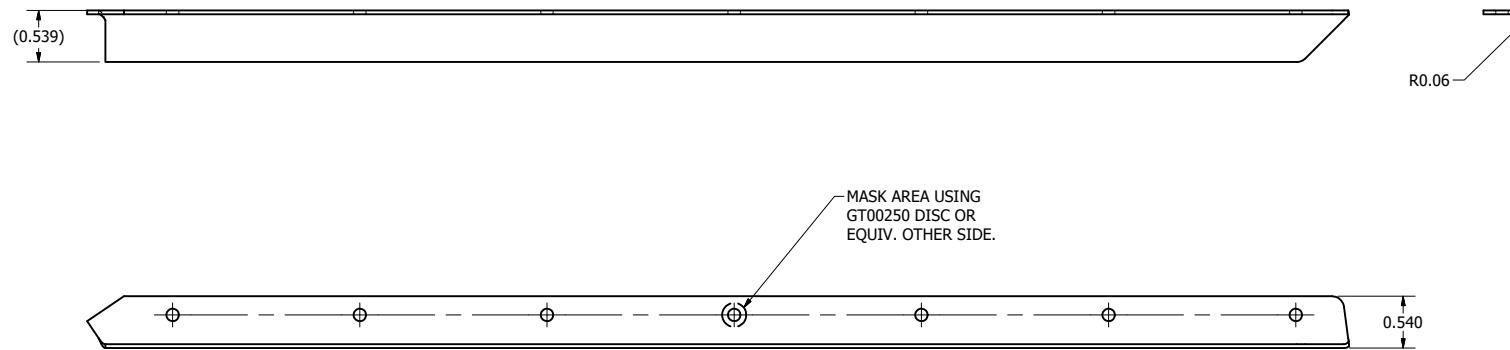
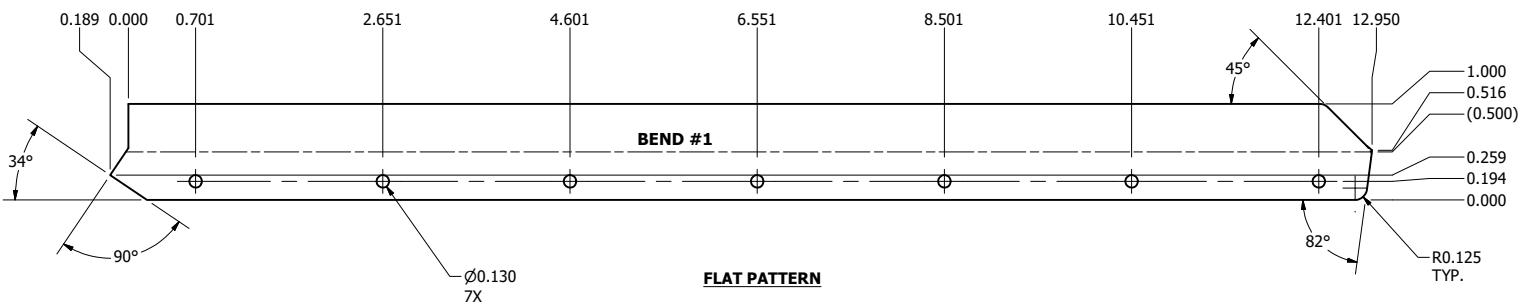
-81 STIFFENER

MATERIAL: 2024-T3 PER AMS 4037, AMS-QQ-A-250/4

STOCK SIZE: 0.040" THK SHEET

FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2, BLACK

OPTIONAL FINISH: BLACK POLYURETHANE POWDER COAT CARDINAL C241-BK303



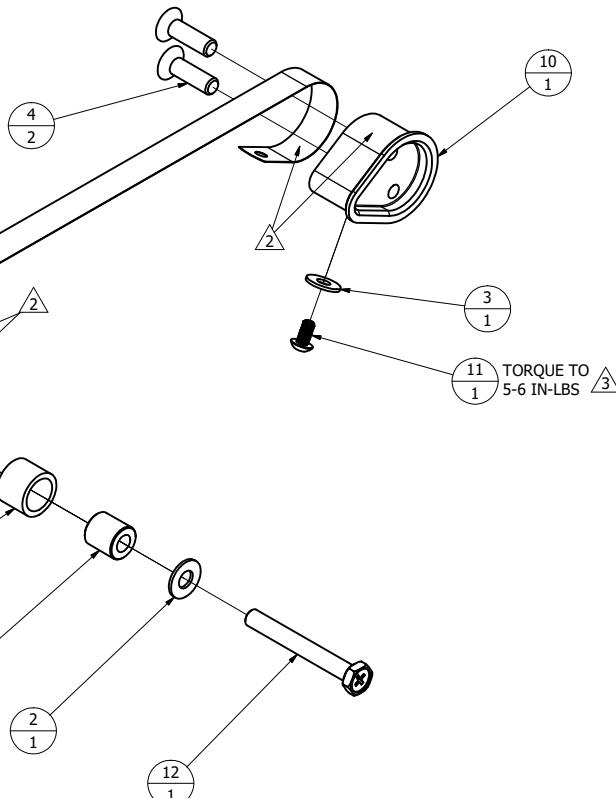
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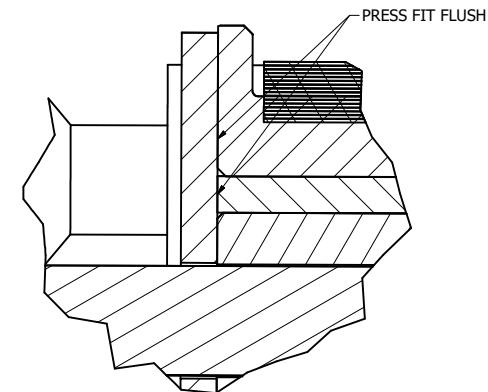
Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16
.X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°				REV G	
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	DO NOT SCALE DRAWING		SHEET 54 OF 66	
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-87 LIGHTNING BONDING ASSEM, RIGHT

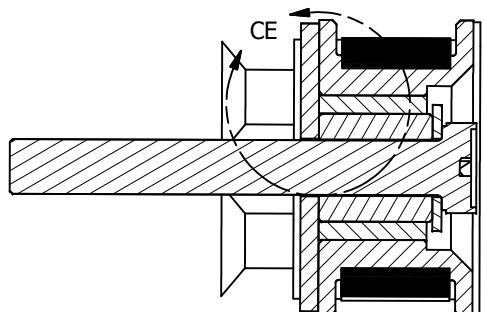
- 1) VERIFY CONSTANT FORCE SPRING HAS NO ROTATIONAL DEGREE OF FREEDOM WHEN INSTALLED ON SPOOL
- 2) VERIFY CONTACT SURFACE BETWEEN COMPONENTS IS CLEAN AND FREE OF DEBRIS TO ENSURE PROPER ELECTRICAL BONDING
- 3) APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT.



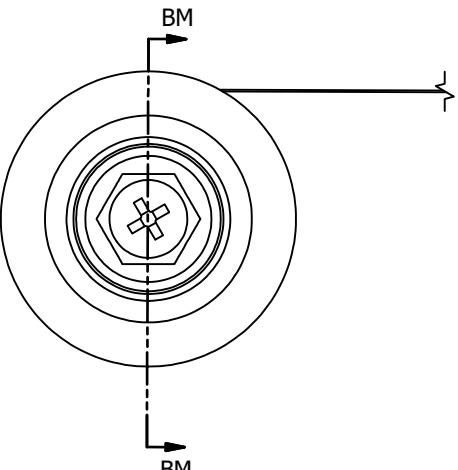
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	NAS1149D0332J	WASHER
3	1	AN960C6	WASHER
4	2	MS24693C273	SCREW
5	1	C208RT-2000-93	TEFLON SPACER
6	1	C208RT-2000-89	SPRING SPOOL
8	1	C208RT-2000-90	SHAFT
9	1	ES38705-1	CONSTANT FORCE SPRING
10	1	C208RT-2000-91	SPRING MOUNT
11	1	ES39528-1	BUTTON HEAD CAP SCREW
12	1	NAS1801-3-24	SCREW
13	1	ES39505-2	BUSHING



DETAIL CE
SCALE 6 : 1



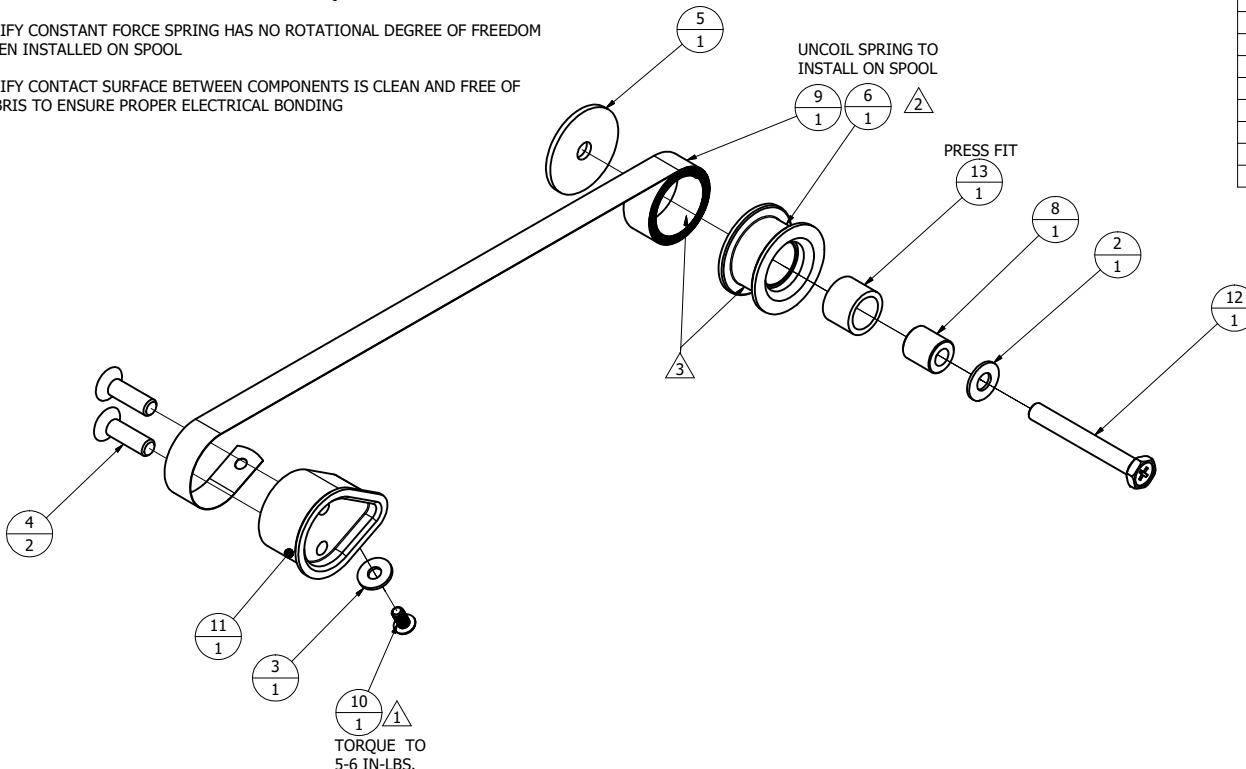
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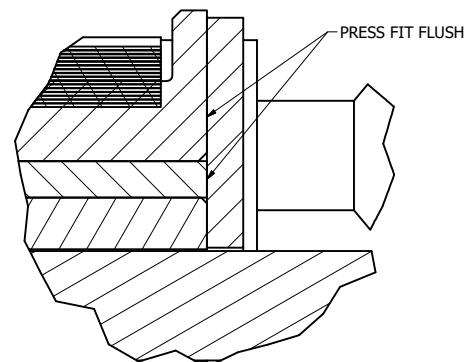
Paravion® Technology		TITLE		DRAWING NUMBER	
		R/T POD DOOR ASSEMBLY		C208RT-2000	
DRAWN BY	CHK'D BY	APPRV'D BY	DATE	REV	ECO
KEW	LS	NLH	7/8/16	G	
DO NOT SCALE DRAWING					
SHEET 56 OF 66					

-88 LIGHTNING BONDING ASSEM, LEFT

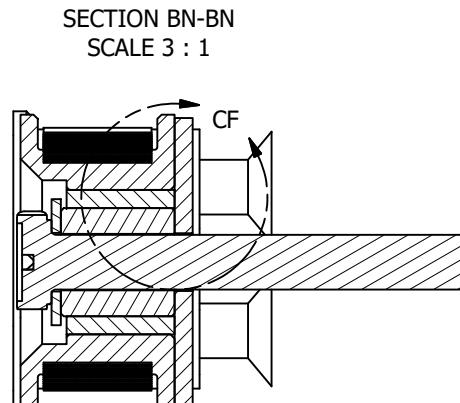
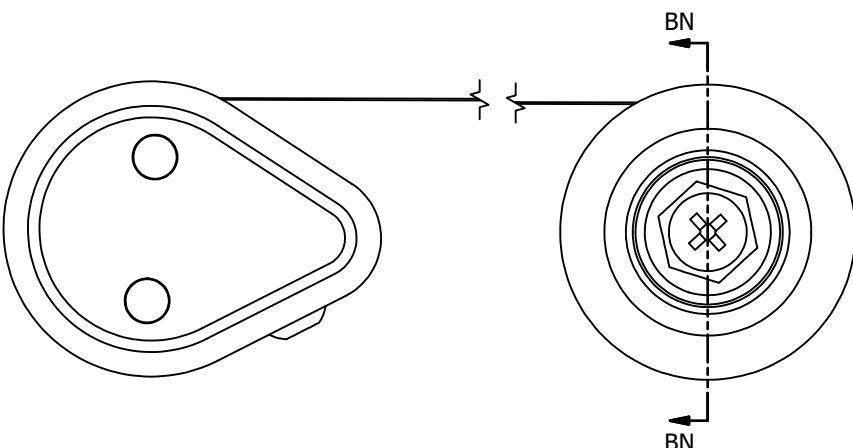
- 1. APPLY LOCTITE RED 26250 THREADLOCKER OR EQUIVALENT
- 2. VERIFY CONSTANT FORCE SPRING HAS NO ROTATIONAL DEGREE OF FREEDOM WHEN INSTALLED ON SPOOL
- 3. VERIFY CONTACT SURFACE BETWEEN COMPONENTS IS CLEAN AND FREE OF DEBRIS TO ENSURE PROPER ELECTRICAL BONDING



PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
2	1	NAS1149D0332J	WASHER
3	1	AN960C6	WASHER
4	2	MS24693C273	SCREW
5	1	C208RT-2000-93	TEFLON SPACER
6	1	C208RT-2000-89	SPRING SPOOL
8	1	C208RT-2000-90	SHAFT
9	1	ES38705-1	CONSTANT FORCE SPRING
10	1	ES39528-1	BUTTON HEAD CAP SCREW
11	1	C208RT-2000-92	SPRING MOUNT
12	1	NAS1801-3-24	SCREW
13	1	ES39505-2	BUSHING



DETAIL CF
SCALE 6 : 1



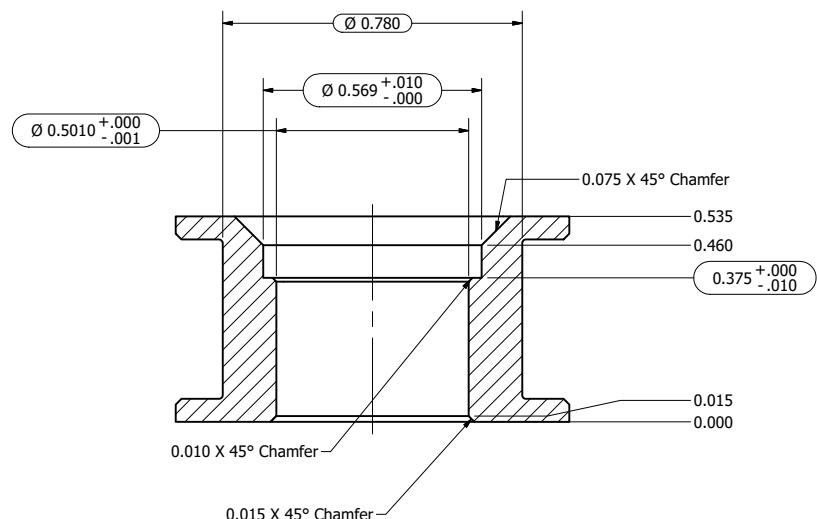
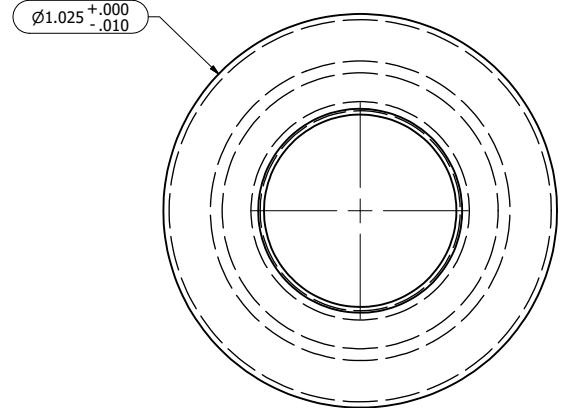
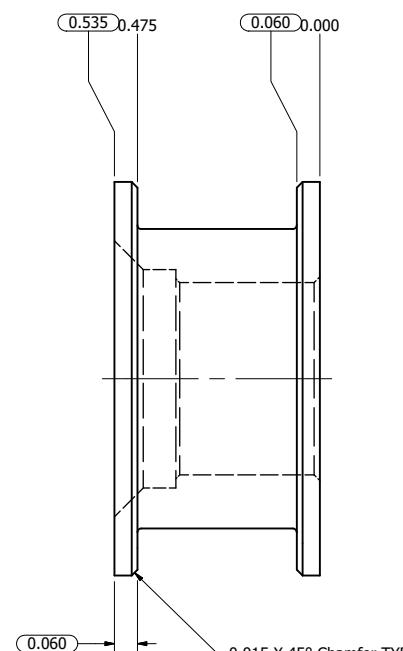
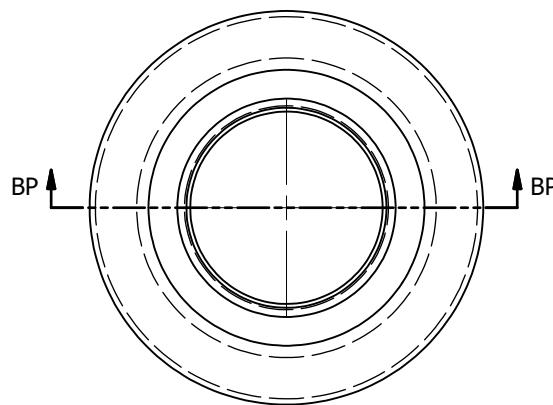
Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY		DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		REV G	ECO		
DO NOT SCALE DRAWING 3RD ANGLE PROJECTION		SHEET 57 OF 66			

-89 SPRING SPOOL

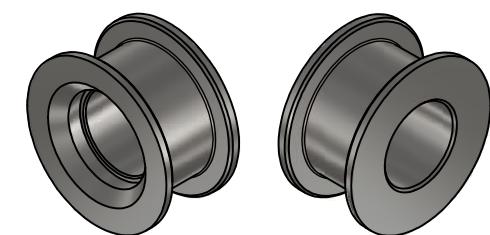
MATERIAL: AISI 304 SS PER AMS 5647
STOCK SIZE: Ø 1.125" ROD
FINISH: PASSIVATION PER ASTM A967

NOTES:

1. BREAK ALL SHARP CORNERS



SECTION BP-BP
SCALE 4 : 1



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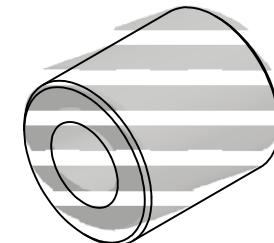
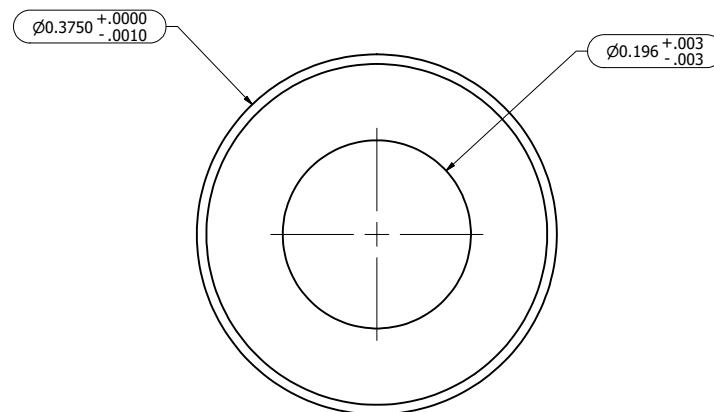
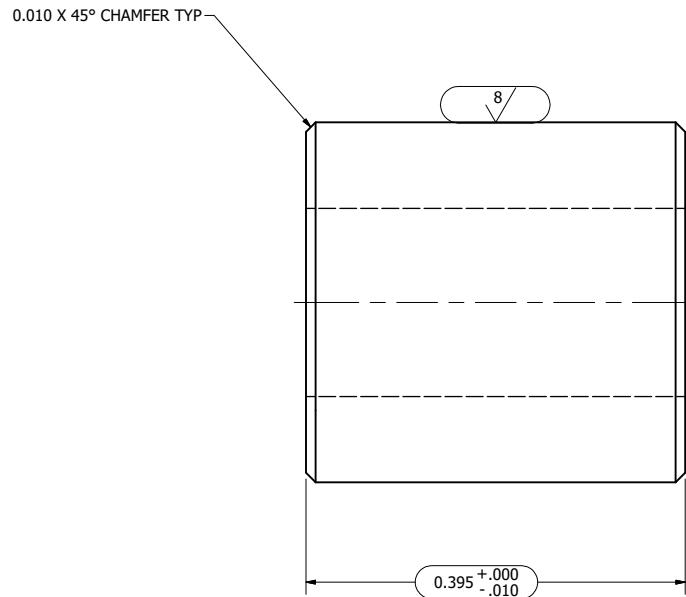
Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY		CHK'D BY	APPRVD. BY
.X = ±.1		KEW	LS	NLH	7/8/16
.XX = ±.05					
.XXX = ±.010					
ANGLES = ± 1°					
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING		SHEET	
3RD ANGLE PROJECTION		© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		58 OF 66	

-90 SHAFT

MATERIAL: AISI 440C PRE-HARDENED AND TEMPERED TO 50-55 HRC
STOCK SIZE: Ø3/8" GROUND ROD
FINISH: NONE

D NOTES:

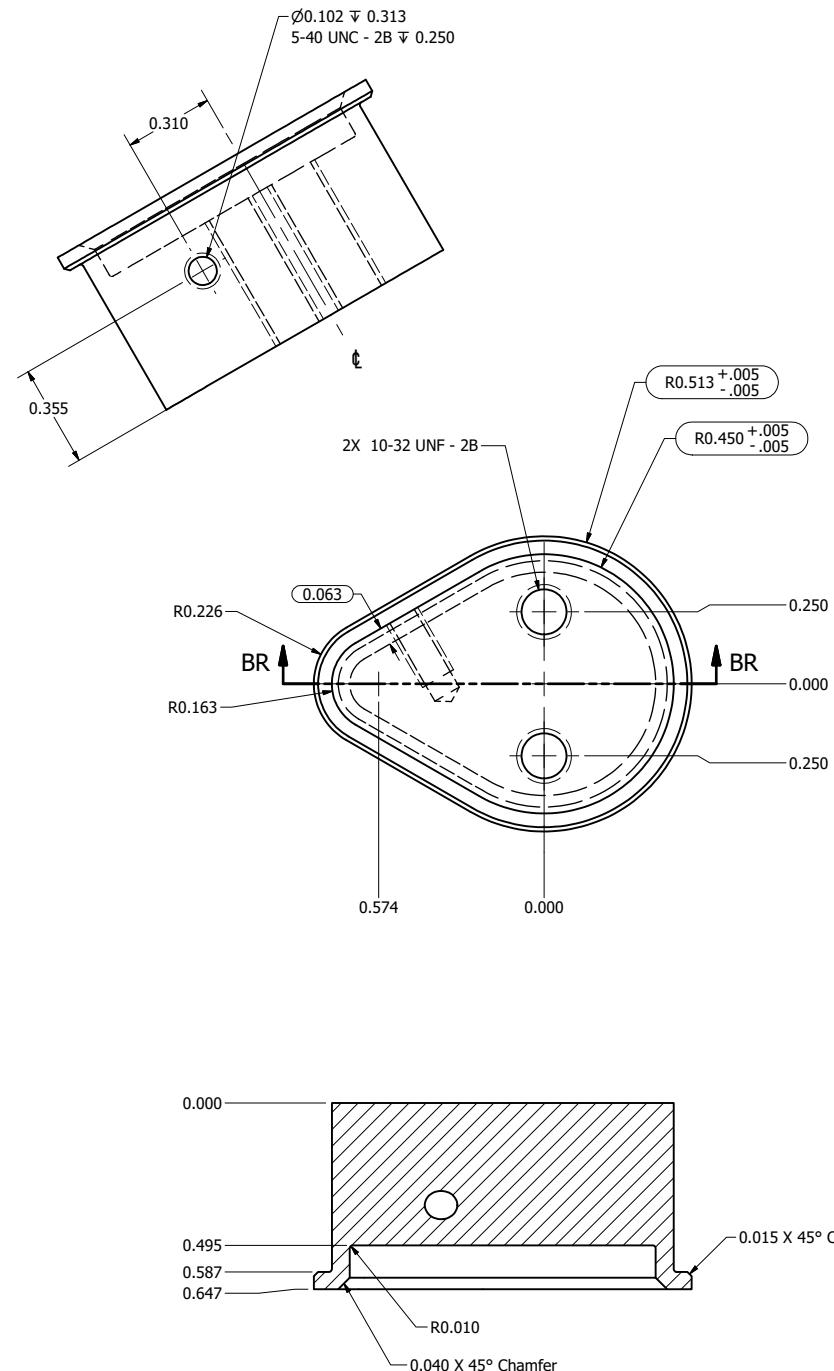
1. MACHINE WITH HEAVY COOLANT / INTERMITTENT OPERATIONS TO AVOID EXCESSIVE HEAT AND SUBSEQUENT TEMPERING OF MATERIAL
2. BREAK ALL SHARP EDGES



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Paravion® Inc.		TITLE		DRAWING NUMBER	
Technology		R/T POD DOOR ASSEMBLY		C208RT-2000	
DIMENSIONS IN INCHES		TOLERANCES EXCEPT			
WHERE NOTED:		.X = ±.1			
.XX = ±.05		.XXX = ±.010			
		ANGLES = ± 1°			
THREADS:					
INTERNAL: CLASS 2B					
EXTERNAL: CLASS 2A					
3RD ANGLE PROJECTION		DO NOT SCALE DRAWING			
		© 2021 PARAVION TECH, INC.			
		PARAVION IS A TRADEMARK OF			
		PARAVION TECHNOLOGY INC.			
		SHEET		59 OF 66	



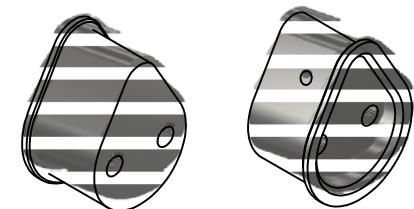
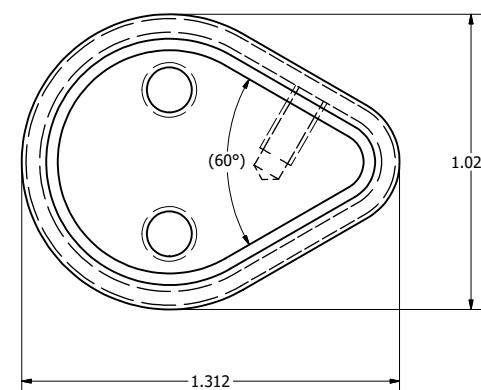
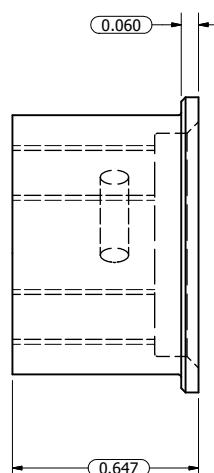
SECTION BR-BR
SCALE 3 : 1

-91 SPRING MOUNT, RIGHT

MATERIAL: AISI 304 SS PER AMS 5647
STOCK SIZE: 0.75" X 1.125" BAR STOCK
FINISH: PASSIVATION PER ASTM A967

NOTES:

1. BREAK ALL SHARP CORNERS



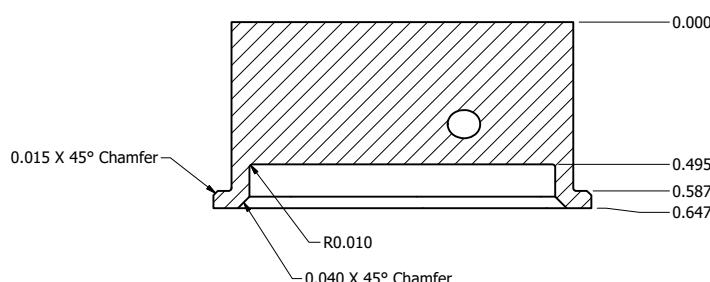
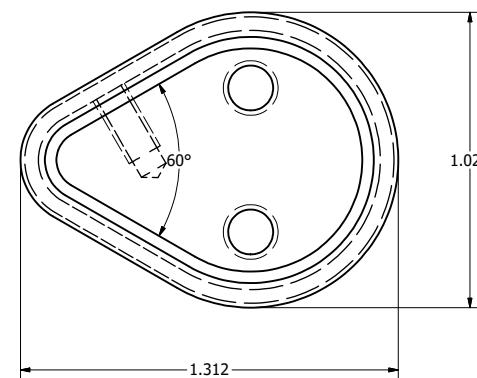
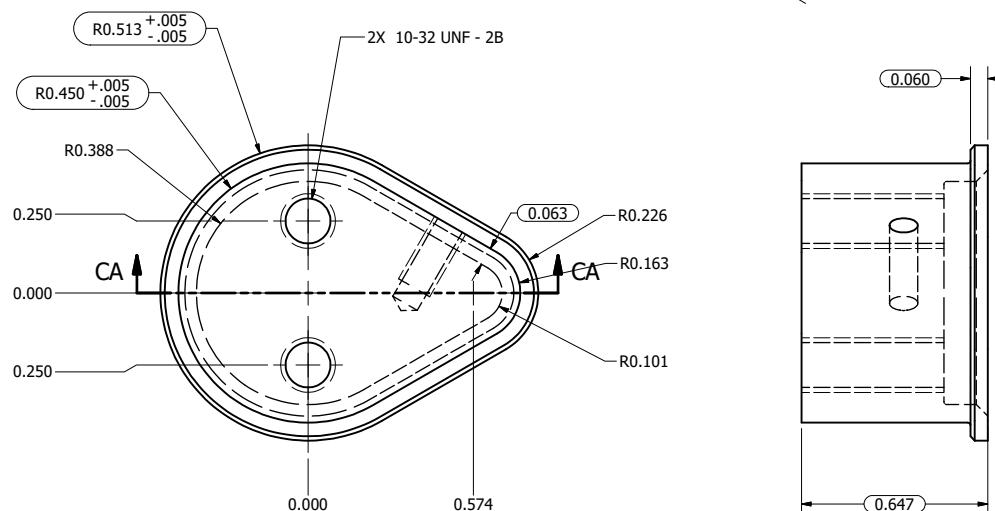
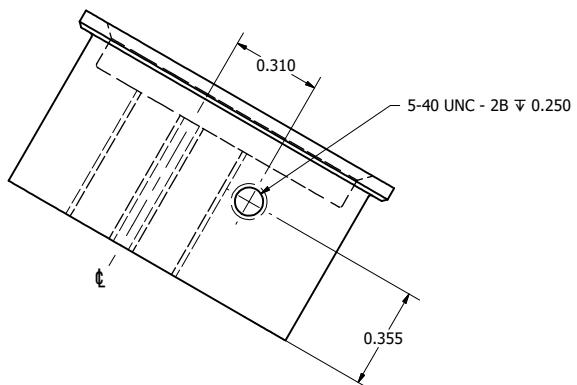
Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY			DRAWING NUMBER C208RT-2000		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPROVED BY NLH	DATE 7/8/16	REV G	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	DO NOT SCALE DRAWING			DATE 7/8/16	SHEET 60 OF 66	
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-92 SPRING MOUNT, LEFT

MATERIAL: AISI 304 SS PER AMS 5647
STOCK SIZE: 0.75" X 1.125" BAR STOCK
FINISH: PASSIVATION PER ASTM A967

NOTES:

1. BREAK ALL SHARP CORNERS



SECTION CA-CA
SCALE 3 : 1

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Paravion® Inc.		TITLE			DRAWING NUMBER		
Technology		R/T POD DOOR ASSEMBLY			C208RT-2000		
DIMENSIONS IN INCHES		TOLERANCES EXCEPT					
DRAWN BY	CHK'D BY	APPROVED BY	DATE	REV	ECO		
KEW	LS	NLH	7/8/16	G			
WHERE NOTED:		.X = ± .1					
.XX = ± .05							
.XXX = ± .010							
ANGLES = ± 1°							
THREADS:		DO NOT SCALE DRAWING			SHEET		
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EXTERNAL: CLASS 2A		PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.					
3RD ANGLE PROJECTION							

4

1

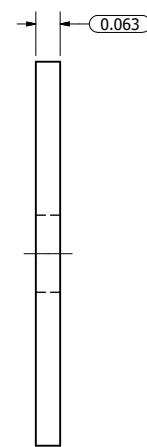
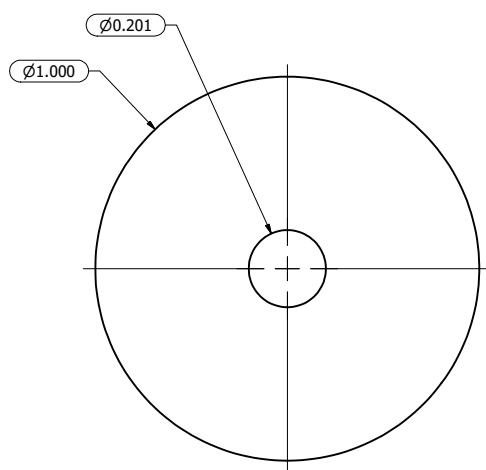
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2

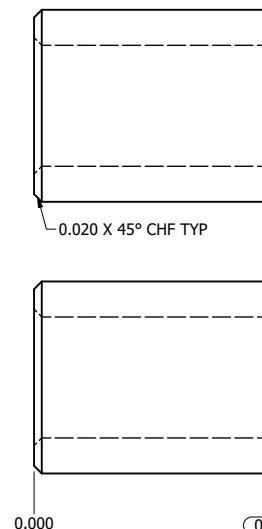
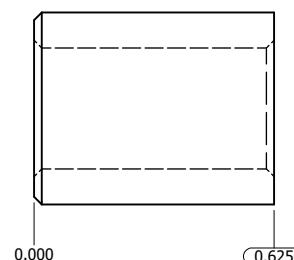
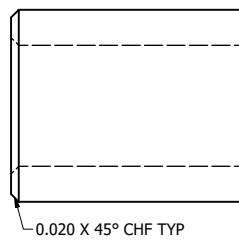
1

-93 TEFILON SPACER

MATERIAL: PTFE G400
FINISH: NONE
COLOR: WHITE

**-94 BUSHING**

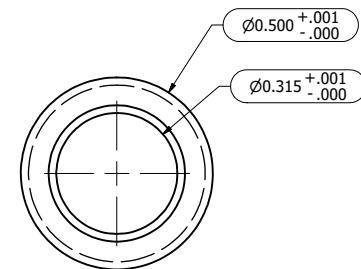
MATERIAL: 6061-T651, AMS 4128, AMS-QQ-A-225/8
FINISH: ANODIZE PER MIL-A-8625 TYPE II, CLASS 2
COLOR: CLEAR



A

C

A



Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY			DRAWING NUMBER C208RT-2000	
DRAWN BY	CHK'D BY	APPVD. BY	DATE	REV	ECO	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°						
KEW	LS	NLH	7/8/16	G		
DO NOT SCALE DRAWING						
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PROTO

4

1

3

2

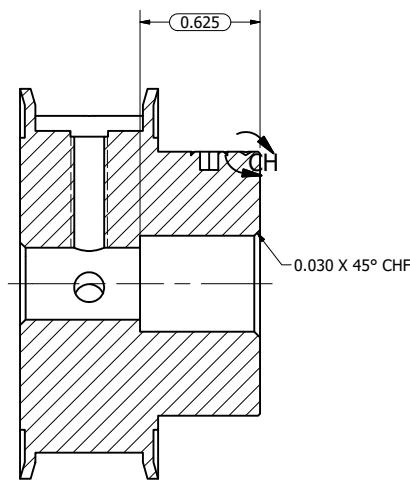
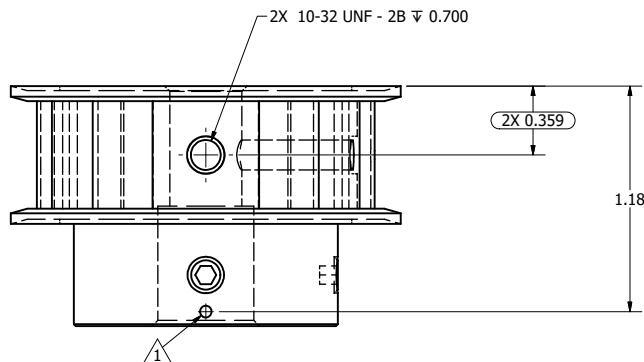
1

-95 TIMING PULLEY

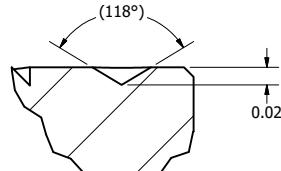
MATERIAL: ES50205-1
FINISH: NONE



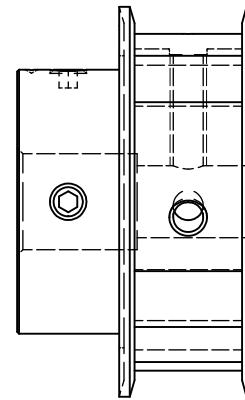
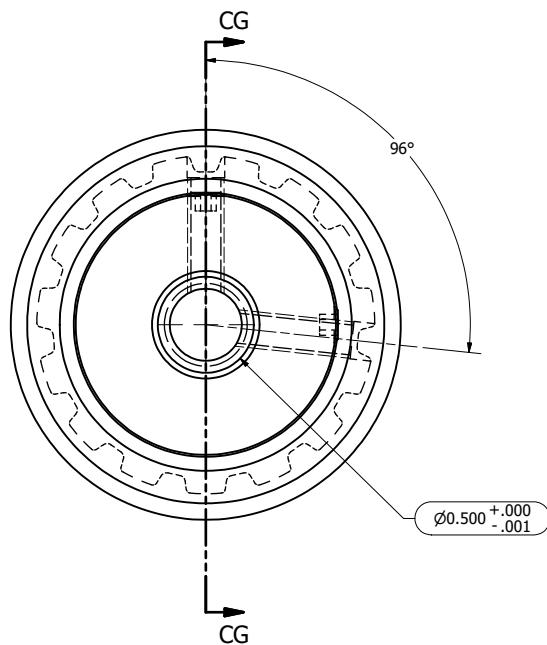
NOTES
⚠ FILL DIMPLE WITH RED ACRYLIC ENAMEL



SECTION CG-CG
SCALE 2 : 1



DETAIL CH
SCALE 10 : 1



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Paravion®
Technology Inc.

TITLE
R/T POD DOOR
ASSEMBLY

DRAWING NUMBER
C208RT-2000

DIMENSIONS IN INCHES
TOLERANCES EXCEPT
WHERE NOTED:
.X = ±.1
.XX = ±.05
.XXX = ±.010
ANGLES = ± 1°

DRAWN BY
KEW
CHK'D BY
LS
APPROVED BY
NLH
DATE
7/8/16

REV
G
ECO

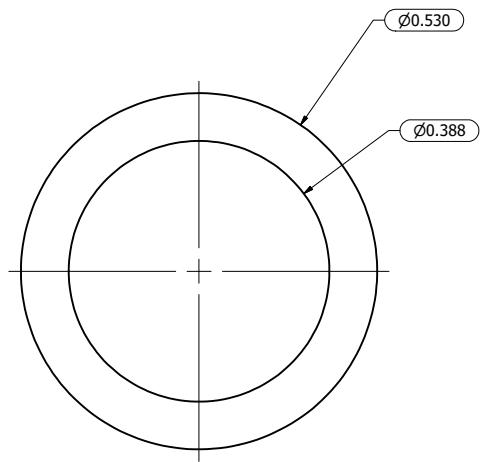
DO NOT SCALE DRAWING
3RD ANGLE
PROJECTION

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63 OF 66

-96 BUSHING

MATERIAL: AISI 304 STAINLESS STEEL
FINISH: NONE



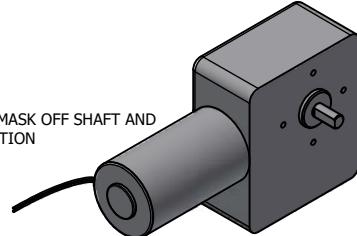
Paravion® Inc. Technology		TITLE R/T POD DOOR ASSEMBLY			DRAWING NUMBER C208RT-2000	
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.X = ±.1						
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PROT0	DRAWN BY KEW	CHK'D BY LS	APPVD BY NLH	DATE 7/8/16	REV G	ECO
DO NOT SCALE DRAWING						
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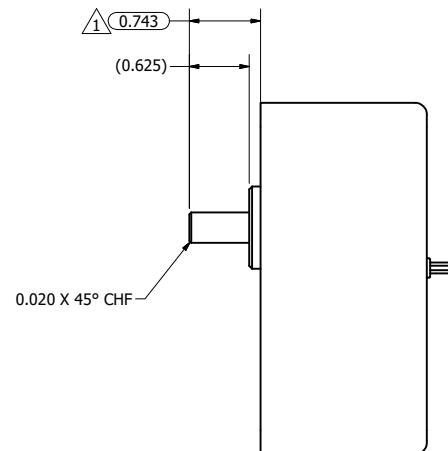
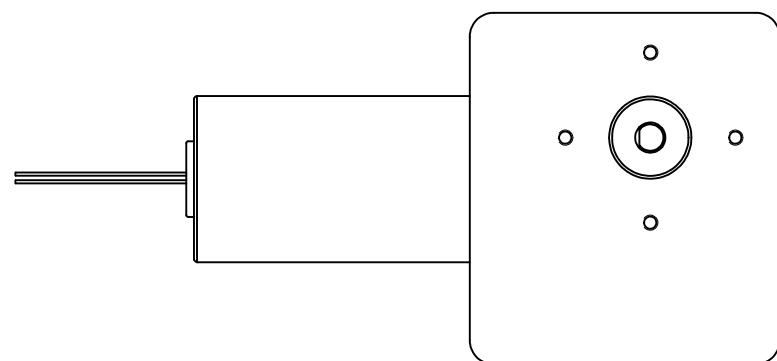
-97 GEAR MOTOR

MATERIAL: ES62200-2

FINISH: CLEAR ACRYLIC ENAMEL, MASK OFF SHAFT AND WIRES PRIOR TO APPLICATION

**NOTES**

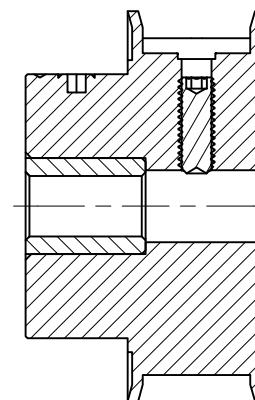
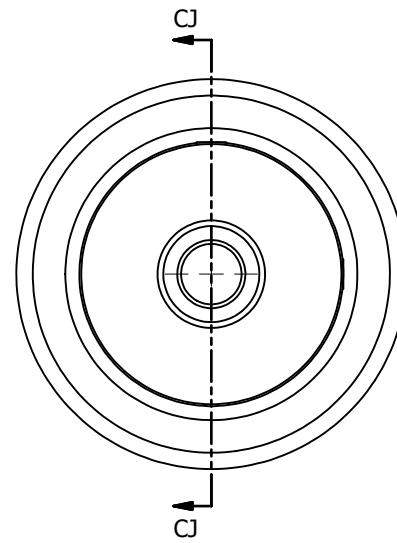
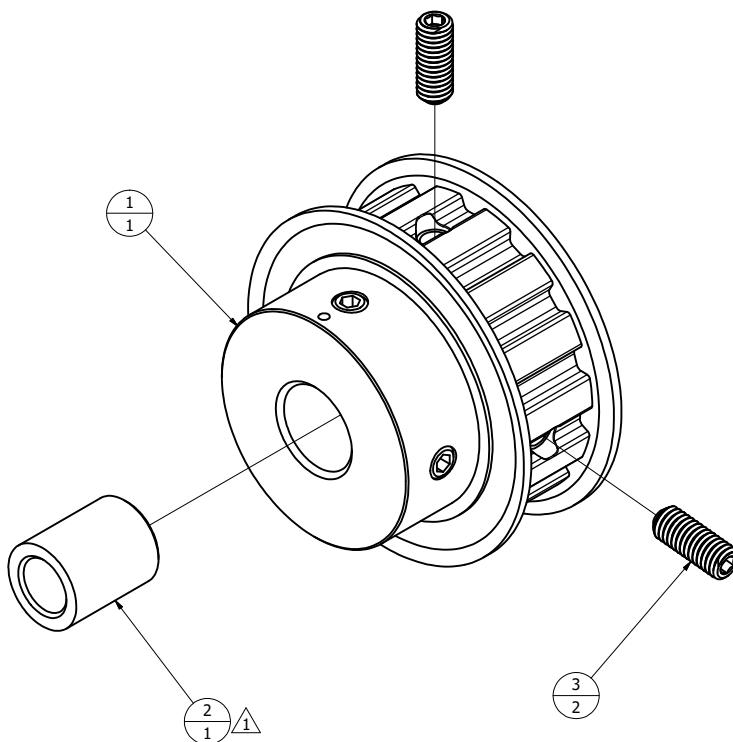
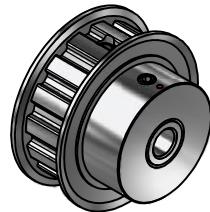
DO NOT USE LIQUID COOLANT, OILS, ETC WITH UNSEALED MOTOR AND GEARBOX. KEEP SHAFT TEMPERATURE AS LOW AS POSSIBLE DURING MACHINING/ SAWING VIA AIR JET OR SIMILAR.



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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY NLH	DATE 7/8/16	REV G	ECO
PROTO	DO NOT SCALE DRAWING	3RD ANGLE PROJECTION	INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.	65 OF 66	SHEET	
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-98 DRIVE TIMING PULLEY ASSEMBLY

⚠ PRESS FIT INTO -95 TIMING PULLEY. THEN LOCATE, DRILL, AND TAP 2X 10-32 UNF TO MATCH EXISTING SET SCREW LOCATIONS



SECTION CJ-CJ
SCALE 2 : 1

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	C208RT-2000-95	TIMING PULLEY
2	1	C208RT-2000-94	BUSHING
3	2	MS51964-53	SET SCREW

Paravion® Inc. Technology	TITLE R/T POD DOOR ASSEMBLY			DRAWING NUMBER C208RT-2000	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY NLH	DATE 7/8/16	REV G	ECO
DO NOT SCALE DRAWING			SHEET		
 3RD ANGLE PROJECTION			66 OF 66		
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